

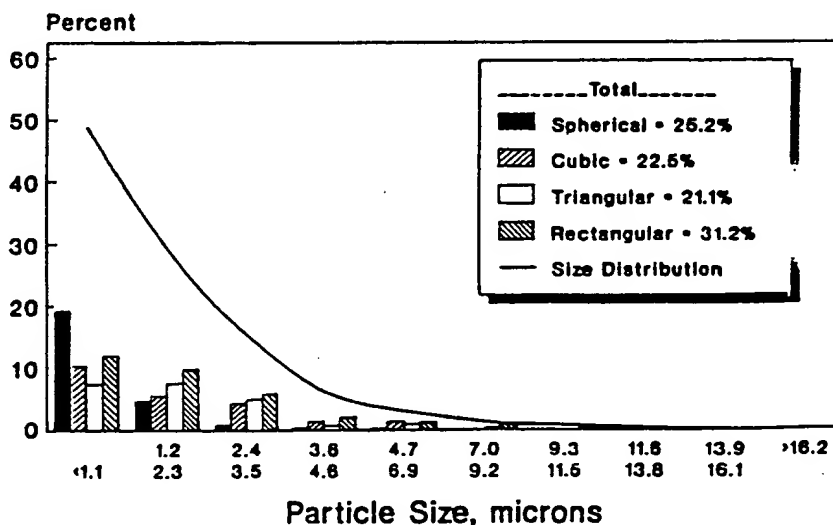


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(54) Title: IMPROVED MAGNETIC MATERIALS AND PROCESS FOR PRODUCING THE SAME



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## (57) Abstract

This invention relates to a process for producing a rare earth-containing material which is resistant to oxidation and non pyrophoric comprising treating the rare earth containing material with a passivating gas at a temperature below the phase transformation temperature of the alloy. Rare earth-containing alloys suitable for use in producing magnets utilizing the powder metallurgy technique, such as Nd-Fe-B and Sm-Co alloys, can be used. The passivating gas can be nitrogen, carbon dioxide or a combination of nitrogen and carbon dioxide. If nitrogen is used as the passivating gas, the resultant rare earth material surface concentration of from 0.4 to about 26.8 atomic percent. If carbon dioxide is used as the passivating gas, the resultant rare earth containing material carbon surface concentration of from about 0.02 to about 15 atomic percent.

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## IMPROVED MAGNETIC MATERIALS AND PROCESS FOR PRODUCING THE SAME

The present application is a continuation-in-part of copending U.S. application Serial No. 07/365,622, filed June 13, 1989, the subject matter of which is incorporated herein by reference.

5                    BACKGROUND OF THE INVENTION

1.    Field of the Invention

                  This invention generally relates to magnetic materials and, more particularly, to rare earth-containing powders, compacts and permanent magnets, and  
10                   a process for producing the same.

2.    Description of the Prior Art

                  Permanent magnet materials currently in use include alnico, hard ferrite and rare earth/cobalt magnets. Recently, new magnetic materials have been  
15                   introduced containing iron, various rare earth elements and boron. Such magnets have been prepared from melt quenched ribbons and also by the powder metallurgy technique of compacting and sintering, which was previously employed to produce samarium cobalt magnets.

20                   Suggestions of the prior art for rare earth permanent magnets and processes for producing the same include: U.S. Patent No. 4,597,938, Matsuura et al., which discloses a process for producing permanent magnet materials of the Fe-B-R type by: preparing a  
25                   metallic powder having a mean particle size of 0.3-80 microns and a composition consisting essentially of, in atomic percent, 8-30% R representing at least one of the rare earth elements inclusive of Y, 2 to 28% B and the balance Fe; compacting; and sintering the resultant  
30                   body at a temperature of 900-1200°C in a reducing or non-oxidizing atmosphere. Co up to 50 atomic percent may be present. Additional elements M (Ti, Ni, Bi, V, Nb, Ta, Cr, Mo, W, Mn, Al, Sb, Ge, Sn, Zr, Hf) may be present. The process is applicable for anisotropic and  
35                   isotropic magnet materials. Additionally, U.S. Patent

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No. 4,684,406, Matsuura et al., discloses a certain sintered permanent magnet material of the Fe-B-R type, which is prepared by the aforesaid process.

Also, U.S. Patent No. 4,601,875, Yamamoto et al., teaches permanent magnet materials of the Fe-B-R type produced by: preparing a metallic powder having a mean particle size of 0.3-80 microns and a composition of, in atomic percent, 8-30% R representing at least one of the rare earth elements inclusive of Y, 2-28% B and the balance Fe; compacting; sintering at a temperature of 900-1200°C; and, thereafter, subjecting the sintered bodies to heat treatment at a temperature lying between the sintering temperature and 350°C. Co and additional elements M (Ti, Ni, Bi, V, Nb, Ta, Cr, Mo, W, Mn, Al, Sb, Ge, Sn, Zr, Hf) may be present. Furthermore, U.S. Patent No. 4,802,931, Croat, discloses an alloy with hard magnetic properties having the basic formula  $RE_{1-x}(TM_{1-y}B_y)_x$ . In this formula, RE represents one or more rare earth elements including scandium and yttrium in Group IIIA of the periodic table and the elements from atomic number 57 (lanthanum) through 71 (lutetium). TM in this formula represents a transition metal taken from the group consisting of iron or iron mixed with cobalt, or iron and small amounts of other metals such as nickel, chromium or manganese.

However, prior art attempts to manufacture permanent magnets utilizing powder metallurgy technology have suffered from substantial shortcomings. For example, crushing is typically carried out in a crushing apparatus using an organic liquid in a gas environment. This liquid may be, for example, hexane, petroleum ether, glycerin, methanol, toluene, or other suitable liquid. A special liquid environment is utilized since the powder produced during crushing is

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5 rare earth metal based and, accordingly, the powder is chemically active, pyrophoric and readily oxidizable. However, the aforementioned liquids are relatively costly and pose a potential health hazard due to their toxicity and flammability. Furthermore, crushing an alloy mass to make suitable powder in the aforementioned environment is also disadvantageous since the powder produced has a high density of certain defects in the crystal structure which adversely affect the magnetic properties. Additionally, crushing in the organic liquid environment unduly complicates the attainment of the desired shape, size, structure, magnetic field orientation and magnetic properties of the powders and resultant magnets since the organic liquid environments have a relatively high viscosity which interferes with achieving the desired results. Moreover, attempts to passivate the surfaces of the powder particles by coating them with a protective substance, such as a resin, nickel or the like, during and after crushing is a generally ineffective and complicated process which increases the cost of manufacturing.

#### SUMMARY OF THE INVENTION

25 This invention relates to a process for producing a rare earth-containing material capable of being formed into a permanent magnet comprising crushing a rare earth-containing alloy and treating the alloy with a passivating gas at a temperature below the phase transformation temperature of the alloy. This invention further relates to a process for producing a rare earth-containing powder comprising crushing a rare earth-containing alloy in a passivating gas at a temperature from ambient temperature to a temperature below the phase transformation temperature of the material.

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This invention also relates to a process for producing a rare earth-containing powder comprising crushing an alloy in water, drying the crushed alloy material at a temperature below the phase transformation temperature of the material, and treating the crushed alloy material with a passivating gas at a temperature from the ambient temperature to a temperature below the phase transformation temperature of the material. Additionally, this invention relates to a process for producing a rare earth-containing powder compact comprising crushing a rare earth-containing alloy in water, compacting the crushed alloy material, drying the compacted alloy material at a temperature below the phase transformation temperature of the material, and treating the compacted alloy material with a passivating gas at a temperature from ambient temperature to a temperature below the phase transformation temperature of the material.

The alloy can comprise, in atomic percent of the overall composition, from about 12% to about 24% of at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and the balance iron. Other rare earth-containing alloys suitable for use in producing permanent magnets utilizing the powder metallurgy technique, such as samarium cobalt alloy, can also be used.

The alloys are crushed to a particle size of from about 0.05 microns to about 100 microns and, preferably, to a particle size of from 1 micron to 40 microns. If the alloys are crushed in water, the crushed or compacted alloy material can be vacuum dried

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or dried with an inert gas, such as argon or helium. The passivating gas can be nitrogen, carbon dioxide or a combination of nitrogen and carbon dioxide. If nitrogen is used as the passivating gas, the resultant powder or compact has a nitrogen surface concentration of from about 0.4 to about 26.8 atomic percent. Moreover, if carbon dioxide is used as the passivating gas, the resultant powder or compact has a carbon surface concentration of from about 0.02 to about 15 atomic percent. The rare earth-containing powder and powder compact produced in accordance with the present invention are non-pyrophoric and resistant to oxidation. Furthermore, the excellent properties displayed by the powders of this invention make them suitable for use in producing magnets, such as bonded or pressed magnets.

The present invention further relates to the production of an improved permanent magnet comprising the steps for producing the rare earth-containing powder set forth above and then compacting the crushed alloy material, sintering the compacted alloy material at a temperature of from about 900°C to about 1200°C, and heat treating the sintered material at a temperature of from about 200°C to about 1050°C.

The present invention also relates to the production of an improved permanent magnet comprising the steps for producing the rare earth-containing powder compact set forth above and then sintering the compacted alloy material at a temperature of from about 900°C to about 1200°C, and heat treating the sintered material at a temperature of from about 200°C to about 1050°C.

The improved permanent magnet in accordance with the present invention includes the type of magnet comprised of, in atomic percent of the overall

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composition, from 12% to 24% of at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and at least 52% iron, wherein the improvement comprises a nitrogen surface concentration of from about 0.4 to about 26.8 atomic percent. The improved permanent magnet can also have a carbon surface concentration of from about 0.02 to about 15 atomic percent if carbon dioxide is used as a passivating gas. These improved permanent magnets have a high resistance to corrosion and superior magnetic properties.

Accordingly, it is an object of the present invention to provide processes for producing rare earth-containing powder and powder compacts which are resistant to oxidation and are non-pyrophoric. It is a further object of the present invention to provide a safe and economically effective process for producing rare earth-containing powder, compacts and magnets. It is also an object of the present invention to provide improved permanent magnets having high resistance to corrosion and superior magnetic properties. These and other objects and advantages of the present invention will be apparent to those skilled in the art upon reference to the following description of the preferred embodiments.

#### BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a graph showing the particle size and shape distribution for Nd-Fe-B powder produced in accordance with the present invention with  $P_a/P_b$  of 1:16 and grinding time of 30 minutes.

FIG. 2 is a graph showing the particle size and shape distribution for Nd-Fe-B powder produced in



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accordance with the present invention with  $P_a/P_b$  of 1:16 and grinding time of 60 minutes.

FIG. 3 is a graph showing the particle size and shape distribution for Nd-Fe-B powder produced in accordance with the present invention with  $P_a/P_b$  of 1:16 and grinding time of 90 minutes.

FIG. 4 is a graph showing the particle size and shape distribution for Nd-Fe-B powder produced in accordance with the present invention with  $P_a/P_b$  of 1:16 and grinding time of 120 minutes.

FIG. 5 is a graph showing the particle size and shape distribution for Nd-Fe-B powder produced in accordance with the present invention with  $P_a/P_b$  of 1:24 and grinding time of 15 minutes.

FIG. 6 is a graph showing the particle size and shape distribution for Nd-Fe-B powder produced in accordance with the present invention with  $P_a/P_b$  of 1:24 and grinding time of 30 minutes.

FIG. 7 is a graph showing the particle size and shape distribution for Nd-Fe-B powder produced in accordance with the present invention with  $P_a/P_b$  of 1:24 and grinding time of 60 minutes.

FIG. 8 is a graph showing the particle size and shape distribution for Nd-Fe-B powder produced in accordance with the present invention with  $P_a/P_b$  of 1:24 and grinding time of 90 minutes.

FIG. 9 is a graph showing the particle size and shape distribution for Nd-Fe-B powder produced in accordance with the present invention with  $P_a/P_b$  of 1:32 and grinding time of 15 minutes.

FIG. 10 is a graph showing the particle size and shape distribution for Nd-Fe-B powder produced in accordance with the present invention with  $P_a/P_b$  of 1:32 and grinding time of 30 minutes.

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FIG. 11 is a graph showing the particle size and shape distribution for Nd-Fe-B powder produced in accordance with the present invention with  $P_a/P_b$  of 1:32 and grinding time of 60 minutes.

5        FIG. 12 is a photomicrograph at 650X magnification of Nd-Fe-B powder produced in accordance with the present invention and oriented in a magnetic field.

10       FIG. 13 is a photomicrograph at 1600X magnification of Nd-Fe-B powder produced in accordance with the present invention.

15       FIG. 14 is a photomicrograph at 1100X magnification of Nd-Fe-B powder produced by conventional powder metallurgy technique and oriented in a magnetic field.

FIG. 15 is an X-ray diffraction pattern of Nd-Fe-B powder produced in accordance with the present invention.

20       FIG. 16 is an X-ray diffraction pattern of Nd-Fe-B powder produced by conventional powder metallurgy technique.

25       FIG. 17 is a graph showing the relationship between residual induction  $B_r$ (kG) on the vertical axis and coercive force  $H_c$ (kOe) as well as maximum energy product  $(BH)_{max}$  (MGOe) on the horizontal axis and comparing a conventional Nd-Fe-B magnet with examples having nitrogen surface concentrations in accordance with the present invention.

30       FIG. 18 is a graph showing the relationship between residual induction  $B_r$ (kG) on the vertical axis and coercive force  $H_c$ (kOe) as well as maximum energy product  $(BH)_{max}$  (MGOe) on the horizontal axis and comparing a conventional Nd-Fe-B magnet with examples having carbon surface concentrations in accordance with  
35       the present invention.

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FIG. 19 is a graph showing the relationship between residual induction  $B_r$  (kG) on the vertical axis and coercive force  $H_c$  (kOe) as well as maximum energy product  $(BH)_{max}$  (MGOe) on the horizontal axis and comparing a conventional Nd-Fe-B magnet with examples having nitrogen and carbon surface concentrations in accordance with the present invention.

FIG. 20 is a graph showing the relationship between residual induction  $B_r$  (kG) on the vertical axis and coercive force  $H_c$  (kOe) as well as maximum energy product  $(BH)_{max}$  (MGOe) on the horizontal axis for an example having nitrogen surface concentration in accordance with the present invention.

FIG. 21 is a graph showing the relationship between residual induction  $B_r$  (kG) on the vertical axis and coercive force  $H_c$  (kOe) as well as maximum energy product  $(BH)_{max}$  (MGOe) on the horizontal axis for an example having nitrogen surface concentration in accordance with the present invention.

FIG. 22 is a graph showing the relationship between residual induction  $B_r$  (kG) on the vertical axis and coercive force  $H_c$  (kOe) as well as maximum energy product  $(BH)_{max}$  (MGOe) on the horizontal axis for an example having nitrogen surface concentration in accordance with the present invention.

FIG. 23 is a graph showing the relationship between residual induction  $B_r$  (kG) on the vertical axis and coercive force  $H_c$  (kOe) as well as maximum energy product  $(BH)_{max}$  (MGOe) on the horizontal axis for a conventional Nd-Fe-B magnet example.

FIG. 24 is a graph showing the relationship between residual induction  $B_r$  (kG) on the vertical axis and coercive force  $H_c$  (kOe) as well as maximum energy product  $(BH)_{max}$  (MGOe) on the horizontal axis for a sintered magnet example having carbon surface

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concentration in accordance with the present invention.

FIG. 25 is a graph showing the relationship between residual induction  $B_r$ (kG) on the vertical axis and coercive force  $H_c$ (kOe) as well as maximum energy product  $(BH)_{max}$  (MGOe) on the horizontal axis for a sintered magnet example having carbon surface concentration in accordance with the present invention.

FIG. 26 is a graph showing the relationship between residual induction  $B_r$ (kG) on the vertical axis and coercive force  $H_c$ (kOe) as well as maximum energy product  $(BH)_{max}$  (MGOe) on the horizontal axis for a sintered magnet example having carbon surface concentration in accordance with the present invention.

FIG. 27 is a graph showing the relationship between residual induction  $B_r$ (kG) on the vertical axis and coercive force  $H_c$ (kOe) as well as maximum energy product  $(BH)_{max}$  (MGOe) on the horizontal axis for a sintered magnet example having nitrogen surface concentration in accordance with the present invention.

FIG. 28 is a graph showing the relationship between residual induction  $B_r$ (kG) on the vertical axis and coercive force  $H_c$ (kOe) as well as maximum energy product  $(BH)_{max}$  (MGOe) on the horizontal axis for a sintered compact example having carbon surface concentration in accordance with the present invention.

FIG. 29 is a graph showing the relationship between residual induction  $B_r$ (kG) on the vertical axis and coercive force  $H_c$ (kOe) as well as maximum energy product  $(BH)_{max}$  (MGOe) on the horizontal axis for a sintered compact example having carbon and nitrogen surface concentration in accordance with the present invention.

FIG. 30 is a graph showing the relationship between residual induction  $B_r$ (kG) on the vertical axis and coercive force  $H_c$ (kOe) as well as maximum energy

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product  $(BH)_{\max}$  (MGOe) on the horizontal axis for a sintered compact example having carbon surface concentration in accordance with the present invention.

FIG. 31 is a graph showing the relationship between residual induction  $B_r$  (kG) on the vertical axis and coercive force  $H_c$  (kOe) as well as maximum energy product  $(BH)_{\max}$  (MGOe) on the horizontal axis for a sintered compact example having nitrogen surface concentration in accordance with the present invention.

10        DESCRIPTION OF THE PREFERRED EMBODIMENTS

In one aspect, the present invention relates to a process for producing a rare earth-containing material capable of being formed into a permanent magnet comprising crushing a rare earth-containing alloy and treating the alloy with a passivating gas at a temperature below the phase transformation temperature of the material. In a further aspect, the present invention relates to a process for producing a rare earth-containing powder comprising crushing a rare earth-containing alloy in a passivating gas at a temperature from ambient temperature to a temperature below the phase transformation temperature of the material.

In another aspect, the present invention relates to a process for producing a rare earth-containing powder comprising: crushing a rare earth-containing alloy in water; drying the crushed alloy material at a temperature below the phase transformation temperature of the material; and treating the crushed alloy material with a passivating gas at a temperature from ambient temperature to a temperature below the phase transformation temperature of the material. The present invention further relates to a process for producing a permanent magnet comprising the above-mentioned processing steps to

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produce a powder and then performing the additional steps of compacting the crushed alloy material, sintering the compacted alloy material at a temperature of from about 900°C to about 1200°C, and heat treating the sintered material at a temperature of from about 200°C to about 1050°C.

In still another aspect, the present invention relates to a process for producing a rare earth-containing powder compact comprising: crushing a rare earth-containing alloy in water; compacting the crushed alloy material; drying the compacted alloy material at a temperature below the phase transformation temperature of the material; and treating the compacted alloy material with a passivating gas at a temperature from ambient temperature to a temperature below the phase transformation temperature of the material. Additionally, this invention relates to a process for producing a permanent magnet comprising the above-mentioned processing steps to produce a powder compact and then performing the additional steps of sintering the compacted alloy material at a temperature of from about 900°C to about 1200°C, and heat treating the sintered material at a temperature of from about 200°C to about 1050°C.

The first processing step of the instant invention involves placing an ingot or piece of a rare earth-containing alloy in a crushing apparatus and crushing the alloy. The crushing can occur in either water or a passivating gas. It is believed that any rare earth-containing alloy suitable for producing powders, compacts and permanent magnets by the conventional powder metallurgy method can be utilized. For example, the alloy can have a base composition of: R-Fe-B, R-Co-B, and R-(Co,Fe)-B wherein R is at least

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one of the rare earth metals, such as Nd-Fe-B;  $\text{RCo}_5$ ,  $\text{R}(\text{Fe}, \text{Co})_5$ , and  $\text{RFe}_5$ , such as  $\text{SmCo}_5$ ;  $\text{R}_2\text{Co}_{17}$ ,  $\text{R}_2(\text{Fe}, \text{Co})_{17}$ , and  $\text{R}_2\text{Fe}_{17}$ , such as  $\text{Sm}_2\text{Co}_{17}$ ; mischmetal-Co, mischmetal-Fe and mischmetal-(Co, Fe); Y-Co, Y-Fe and Y-(Co, Fe); or  
5 other similar alloys known in the art. The R-Fe-B alloy compositions disclosed in U.S. Patent Nos. 4,597,938 and 4,802,931, the texts of which are incorporated by reference herein, are particularly suitable for use in accordance with the present  
10 invention.

In one preferred embodiment, the rare earth-containing alloy comprises, in atomic percent of the overall composition, from about 12% to about 24% of at least one rare earth element selected from the group  
15 consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and the balance iron. Preferably, the rare  
20 earth element is neodymium and/or praseodymium. However,  $\text{RM}_5$  and  $\text{R}_2\text{M}_{17}$  type rare earth alloys, wherein R is at least one rare earth element selected from the group defined above and M is at least one metal selected from the group consisting of Co, Fe, Ni, and  
25 Mn may be utilized. Additional elements Cu, Ti, Bi, V, Nb, Ta, Cr, Mo, W, Mn, Al, Sb, Ge, Sn, Zr and Hf, may also be utilized.  $\text{RCo}_5$  and  $\text{R}_2\text{Co}_{17}$  are preferred for this type. The alloys, as well as the powders, compacts and magnets produced therefrom in accordance  
30 with the present invention, may contain, in addition to the above-mentioned base compositions, impurities which are entrained from the industrial process of production.

In one embodiment, the alloys are crushed in  
35 water to produce particles having a particle size of

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from about 0.05 microns to about 100 microns and, preferably, from 1 micron to 40 microns, although larger size particles, such as up to about 300 microns, can also be utilized. Advantageously, the particle size is from 2 to 20 microns. The time required for crushing is not critical and will, of course, depend upon the efficiency of the crushing apparatus. The crushing is performed in water to prevent oxidation of the crushed alloy material. Furthermore, water has a low coefficient of viscosity and, therefore, crushing in water is more effective and faster than crushing in organic liquids presently utilized in the art. Also, crushing in water provides a higher defect density of domain wall pinning sites in the individual alloy particles, thereby providing better magnetic properties for the magnets produced from the powder or powder compact. Finally, the size and shape of the individual alloy particles is optimized for compacting of the powder in a magnetic field to produce magnets. The type of water utilized is not critical. For example, distilled, deionized or non-distilled water may be utilized, but distilled is preferred.

In the aforesaid embodiment, after crushing, the crushed alloy material is then dried at a temperature below the phase transformation temperature of the material. More particularly, the crushed alloy material is dried thoroughly at a temperature which is sufficiently low so that phase transformation of the alloy material is not induced. The term "phase transformation temperature" as used herein means the temperature at which the stoichiometry and crystal structure of the base rare earth-containing alloy changes to a different stoichiometry and crystal structure. For example, crushed alloy material having a base composition of Nd-Fe-B will undergo phase



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transformation at a temperature of approximately 580°C. Accordingly, the Nd-Fe-B crushed alloy material should be dried at a temperature below about 580°C. However, as can be appreciated by those skilled in the art, the particular phase transformation temperature necessary for the alloy material utilized will vary depending on the exact composition of the material and this temperature can be determined experimentally for each such composition.

10                    Preferably, the wet crushed alloy material is first put in a centrifuge or other appropriate equipment for quickly removing most of the water from the material. The material can then be vacuum dried or dried with an inert gas, such as argon or helium. The crushed alloy material can be effectively dried by the flow or injection of the inert gas at a pressure below 760 torr. Nevertheless, regardless of the drying technique, the drying must be performed at a temperature below the aforementioned phase transformation temperature of the material.

15                    In another embodiment, after crushing, the crushed alloy material is first compacted before drying to form wet compacted material. Preferably, the material is compacted at a pressure of 0.5 to 12 T/cm<sup>2</sup>. Nevertheless, the pressure for compaction is not critical. However, the resultant compact should have interconnected porosity and sufficient green strength to enable the compact to be handled. Advantageously, the interconnected porosity can be obtained during drying of the compact. The term "interconnected porosity" as used herein means a network of connecting pores is present in the compact in order to permit a fluid or gas to pass through the compact. The compaction is performed in a magnetic field to produce anisotropic permanent magnets. Preferably, a magnetic

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field of about 7 to 15 kOe is applied in order to align the particles. Moreover, a magnetic field is not applied during compaction when producing isotropic permanent magnets. In either case, the compacted alloy material can be thereafter dried at a temperature below the phase transformation temperature of the material as described above. However, the compaction and drying steps can be combined if desired so that the compaction and drying occur simultaneously. Furthermore, it is believed that the compaction and drying steps can even be reversed (i.e. dry the crushed alloy material first and then compact the material) if a protective atmosphere is provided until the compact is treated with a passivating gas.

Subsequently, the crushed or compacted alloy material is treated with a passivating gas at a temperature from ambient temperature to a temperature below the phase transformation temperature of the material. If the wet crushed or compacted material was dried in a vacuum box, then the material can be treated with the passivating gas by injecting the gas into the box. The term "passivating gas" as used herein means a gas suitable for passivation of the surface of the crushed material, powder or compacted powder particles so as to produce a thin layer on the surface of the particles in order to protect it from corrosion and/or oxidation. The passivating gas can be nitrogen, carbon dioxide or a combination of nitrogen and carbon dioxide. The temperature at which the powder or compacted powder particles is treated is critical and must be below the phase transformation temperature of the material. For example, the maximum temperature for treatment must be below about 580°C when a Nd-Fe-B composition is used for the material. Generally, the higher the temperature, the less the time required for

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treatment with the passivating gas, and the smaller the particle size of the material, the lower the temperature and the shorter the time required for treatment. Preferably, crushed or compacted alloy material of the Nd-Fe-B type is treated with the passivating gas from about one minute to about 60 minutes at a temperature from about 20°C to about 580°C and, advantageously, at a temperature of about 175°C to 225°C.

10 In another embodiment of the present invention, the powder is produced by placing an ingot or piece of the rare earth-containing alloy in a crushing apparatus, such as an attritor or ball mill, and then purging the apparatus with a passivating gas to displace the air in the apparatus. The alloy is crushed in the passivating gas to a particle size of from about 0.05 microns to about 100 microns and, preferably, from 1 micron to 40 microns, although larger size particles, such as up to about 300 microns, can also be utilized. The time required for crushing is not critical and will, of course, depend upon the efficiency of the crushing apparatus. Furthermore, the crushing apparatus may be set-up to provide a continuous operation for crushing the alloy in a passivating gas. However, the temperature at which the alloy material is crushed in passivating gas is critical and must be below the phase transformation temperature of the material as defined above. Additionally, the passivating gas pressure and the amount of time the alloy material is crushed in the passivating gas must be sufficient to obtain the nitrogen or carbon surface concentration in the resultant powder and magnet as noted below.

30 When nitrogen is used as the passivating gas in accordance with the present invention, the resultant

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powder or powder compact has a nitrogen surface concentration of from about 0.4 to about 26.8 atomic percent and, preferably, 0.4 to 10.8 atomic percent. Furthermore, when carbon dioxide is used as the passivating gas, the resultant powder or powder compact has a carbon surface concentration of from about 0.02 to about 15 atomic percent and, preferably, 0.5 to 6.5 atomic percent. When a combination of nitrogen and carbon dioxide is utilized, the resultant powder or powder compact can have a nitrogen surface concentration and carbon surface concentration within the above-stated ranges.

The term "surface concentration" as used herein means the concentration of a particular element in the region extending from the surface to a depth of 25% of the distance between the center of the particle and surface. For example, the surface concentration for a particle having a size of 5 microns will be the region extending from the surface to a depth of 0.625 microns. Preferably, the region extends from the surface to a depth of 10% of the distance between the center of the particle and surface. This surface concentration can be measured by Auger electron spectroscopy (AES), as can be appreciated by those skilled in the art. AES is a surface-sensitive analytical technique involving precise measurements of the number of emitted secondary electrons as a function of kinetic energy. More particularly, there is a functional dependence of the electron escape depth on the kinetic energy of the electrons in various elements. In the energy range of interest, the escape depth varies in the 2 to 10 monolayers regime. The spectral information contained in the Auger spectra are thus to a greater extent representative of the top 0.5 to 3 nm of the surface. See Metals Handbook®, Ninth

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Edition, Volume 10, Materials Characterization, American Society for Metals, pages 550-554 (1986), which is incorporated by reference herein.

In a preferred embodiment, the present invention further provides for an unique non-pyrophoric rare earth-containing powder and powder compact comprising, in atomic percent of the overall composition, from about 12% to about 24% of at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and at least 52% iron, and further having a nitrogen surface concentration of from about 0.4 to about 26.8 atomic percent. Preferably, the rare earth element of the alloy powder or powder compact is neodymium and/or praseodymium and the nitrogen surface concentration is from 0.4 to 10.8 atomic percent. In another preferred embodiment, the present invention provides for an unique non-pyrophoric rare earth-containing powder and powder compact comprising, in atomic percent of the overall composition, from 12% to 24% of at least one rare earth element, selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and at least 52% iron, and further having a carbon surface concentration of from about 0.02 to about 15 atomic percent. Preferably, the rare earth element is neodymium and/or praseodymium and the carbon surface concentration is from 0.5 to 6.5 atomic percent. The above-mentioned rare earth-containing powders and powder compacts are

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not only non-pyrophoric, but also resistant to oxidation and can be used to produce permanent magnets having superior magnetic properties.

5 The present invention further encompasses a process for producing a permanent magnet. In one embodiment, this process comprises:

10 a) crushing a rare earth-containing alloy in a passivating gas for about 1 minute to about 60 minutes at a temperature from about 20°C to about 580°C to a particle size of from about 0.05 microns to about 100 microns, said alloy comprising, in atomic percent of the overall composition, of from about 12% to about 24% of at least one rare earth element selected from the group consisting of neodymium, 15 praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and the balance iron;

20 b) compacting the crushed alloy material;

c) sintering the compacted alloy material at a temperature of from about 900°C to about 1200°C; and

25 d) heat treating the sintered material at a temperature from about 200°C to about 1050°C.

The crushing step (step a) is the same as disclosed above for producing powder when the alloy is crushed in a passivating gas.

30 In a further embodiment, the process for producing a permanent magnet in accordance with the present invention comprises:

a) Crushing a rare earth-containing alloy in water to a particle size of from about 0.05 35 microns to about 100 microns, the rare earth-containing

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alloy comprising, in atomic percent of the overall composition, of from about 12% to about 24% of at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and the balance iron;

5                   b)   Drying the crushed alloy material  
10   at a temperature below the phase transformation  
temperature of the material;

                  c)   Treating the crushed alloy material  
with a passivating gas from about 1 minute to 60  
minutes at a temperature of from about 20°C to 580°C;

15                   d)   Compacting the crushed alloy  
material;

                  e)   Sintering the compacted alloy  
material at a temperature of from about 900°C to about  
1200°C; and

20                   f)   Heat treating the sintered material  
at a temperature of from about 200°C to about 1050°C.

                  The crushing, drying, and treating steps  
(steps a through c) are the same as disclosed above for  
producing powder when the alloy is crushed in water.

25                   However, to produce permanent magnets in each  
of the above-mentioned embodiments, the powders are  
subsequently compacted, preferably at a pressure of 0.5  
to 12 T/cm<sup>2</sup>. Nevertheless, the pressure for compaction  
is not critical. The compaction is performed in a  
30   magnetic field to produce anisotropic permanent  
magnets. Preferably, a magnetic field of about 7 to 15  
kOe is applied in order to align the particles.  
Moreover, a magnetic field is not applied during  
compaction when producing isotropic permanent magnets.  
35   In either case, the compacted alloy material is

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sintered at a temperature of from about 900°C to about 1200°C and, preferably, 1000°C to 1180°C. The sintered material is then heat treated at a temperature of from about 200°C to about 1050°C.

5 In another embodiment, the process for producing a permanent magnet in accordance with the present invention comprises:

10 a) crushing a rare earth-containing alloy in water to a particle size of from about 0.05 microns to about 100 microns, said alloy comprising, in atomic percent of the overall composition, of from about 12% to about 24% of at least one rare earth element, selected from the group consisting of  
15 neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and the balance iron;

20 b) compacting the crushed alloy material;

c) drying the compacted alloy material at a temperature below the phase transformation temperature of the material;

25 d) treating the compacted alloy material with a passivating gas for about 1 minute to about 60 minutes at a temperature from about 20°C to about 580°C;

30 e) sintering the compacted alloy material at a temperature of from about 900°C to about 1200°C; and

f) heat treating the sintered material at a temperature from about 200°C to about 1050°C.

35 The crushing, compacting, drying and treating steps (steps a through d) are the same as disclosed above for producing compacts. However, the compacted



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alloy material is thereafter sintered and heat treated to produce permanent magnets.

When nitrogen is used as the passivating gas to treat the alloy material, the resultant permanent magnet will have a nitrogen surface concentration of from about 0.4 to about 26.8 atomic percent and, preferably, 0.4 to 10.8 atomic percent. When carbon dioxide is used as the passivating gas, the resultant permanent magnet will have a carbon surface concentration of from about 0.02 to about 15 atomic percent and, preferably, from 0.5 to 6.5 atomic percent. Of course, if a combination of nitrogen and carbon dioxide is used, the surface concentrations of the respective elements will be within the above-stated ranges.

Another preferred embodiment of the present invention includes an improved permanent magnet of the type comprised of, in atomic percent of the overall composition, from about 12% to about 24% of at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and at least 52% iron, wherein the improvement comprises a nitrogen surface concentration of from about 0.4 to about 26.8 atomic percent and, preferably, from 0.4 to 10.8 atomic percent. The preferred rare earth element is neodymium and/or praseodymium. A further preferred embodiment is an improved permanent magnet of the type comprised of, in atomic percent of the overall composition, from about 12% to about 24% of at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium,

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holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and at least 52% iron, wherein the improvement comprises a carbon surface concentration of from about 0.02 to about 15 atomic percent and, preferably, 0.5 to 6.5 atomic percent. The preferred rare earth element is also neodymium and/or praseodymium. The present invention is applicable to either anisotropic or isotropic permanent magnet materials, although isotropic materials have lower magnetic properties compared with the anisotropic materials.

The permanent magnets in accordance with the present invention have a high resistance to corrosion, highly developed magnetic and crystallographic texture, and high magnetic properties (coercive force, residual induction, and maximum energy product). In order to more clearly illustrate this invention, the examples set forth below are presented. The following examples are included as being illustrations of the invention and should not be construed as limiting the scope thereof.

#### EXAMPLES

Alloys were made by induction melting a mixture of substantially pure commercially available forms of elements to produce the following composition in weight percent: Nd - 35.2%, B - 1.2%, Dy - 0.2%, Pr - 0.4%, Mn - 0.1%, Al - 0.1% and Fe - balance. Powders and permanent magnets were then prepared from this base composition in accordance with the present invention. The alloys were crushed in distilled water, dried in vacuum and treated with a passivating gas.

FIGS. 1-11 illustrate the distribution of particle size and shape of powder for various weight ratios between powder and milling balls ( $P_a/P_b$ ) and

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grinding times. The powder samples were oriented in a magnetic field and measurements were made on a plane perpendicular to the magnetic field. FIGS. 1-11 show that the particle size and shape of powder produced in accordance with the present invention were optimized for compacting of the powder in a magnetic field to produce magnets since the number of desired rectangular shaped particles was maximized.

FIG. 12 illustrates a distribution of particle size and shape of Nd-Fe-B powder produced in accordance with the present invention and oriented in a magnetic field ( $H_e$ ) as shown in the figure. FIG. 13 illustrates Nd-Fe-B powder produced in accordance with the present invention wherein the nitrogen containing surface layer is visible. FIG. 14 illustrates Nd-Fe-B powder produced by conventional powder metallurgy technique with the powder crushed in hexane and oriented in a magnetic field ( $H_e$ ) as shown in the figure. Corrosion is evident in the conventional powder illustrated in FIG. 14.

FIG. 15 is an X-ray diffraction pattern of Nd-Fe-B powder produced in accordance with the present invention and FIG. 16 is an X-ray diffraction pattern of Nd-Fe-B powder produced by conventional powder metallurgy technique. Comparison of FIG. 15 and FIG. 16 illustrates the difference in peak widths which indicates a higher defect density of domain wall pinning sites in the individual particles of the present invention. Comparison of FIG. 15 and FIG. 16 also illustrates the difference in peak widths which indicates a higher density of defects that nucleate domains in the individual particles of the conventional powder, which adversely affect magnetic properties.

Powders and permanent magnets were prepared from the above-mentioned base composition in accordance

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with the present invention and the experimental parameters, including: the weight ratio between powder and milling balls ( $P_a/P_b$ ), the length of time (T) the alloys were crushed in minutes, the typical particle size range of the powder after crushing ( $D_p$ ) in microns, and the temperature at which the powder was treated with the passivating gas ( $T_p$ ) in degrees centigrade, are given below in Table I. Nitrogen was used as the passivating gas for Samples 1, 4, 7 and 10. Carbon dioxide was used as the passivating gas for Samples 2, 5, 8, and 11. A combination of nitrogen and carbon dioxide was used as the passivating gas for Samples 3, 6, 9 and 12. Sample 13 is a prior art sample made by conventional methods for comparison. FIG. 14 is a photomicrograph of Sample 13 and FIG. 16 is an X-ray diffraction pattern of Sample 13. Each powder sample was compacted, sintered and heat treated. Magnetic properties were measured, and residual induction and maximum energy product were corrected for 100% density. The magnetic properties included magnetic texture (A %-calculated), average grain size in the sintered magnet ( $D_g$ ), intrinsic coercive force  $H_{ci}$ (kOe), coercive force  $H_c$ (kOe), residual induction  $B_r$ (kG), maximum energy product  $(BH)_{max}$ (MGOe), and corrosion activity. The corrosion activity was measured visually after the samples had been exposed to 100% relative humidity for about two weeks (N - no corrosion observed, A - full corrosive activity observed, and S - slight corrosive activity observed). These results are also reported in Table I below. As can be seen from the results reported in Table I, the improved permanent magnets produced in accordance with the present invention exhibit superior magnetic properties. These results are further illustrated in FIG. 17 which is a graph showing the relationship

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between residual induction  $B_r$ (kG) on the vertical axis and coercive force  $H_c$ (kOe) as well as maximum energy product  $(BH)_{max}$ (MGOe) on the horizontal axis for Samples 1, 4, 7 and 10 having nitrogen surface concentrations in accordance with the present invention, and prior art Sample 13. FIG. 18 illustrates the relationship between  $B_r$ (kG) on the vertical axis and  $H_c$ (kOe) as well as  $(BH)_{max}$ (MGOe) on the horizontal axis for Samples 2, 5, 8 and 11 having carbon surface concentrations in accordance with the present invention, and prior art Sample 13. FIG. 19 illustrates the relationship between  $B_r$ (kG) on the vertical axis and  $H_c$ (kOe) as well as  $(BH)_{max}$ (MGOe) on the horizontal axis for Samples 3, 6, 9 and 12 having both nitrogen and carbon surface concentrations in accordance with the present invention, and prior art Sample 13.

TABLE I

Sample Number	P <sub>A</sub> /P <sub>B</sub>	T (min)	D <sub>p</sub> (μm)	T <sub>p</sub> (°C)	Surface Concentration (Atomic %)		A (%)	D <sub>g</sub> (μm)	H <sub>Cl</sub> (kOe)	H <sub>C</sub> (kOe)	B <sub>r</sub> (kG)	(BH) <sub>max</sub> (MGoe)	Corrosion Activity
					N	C							
1	1:24	30	0.5 - 5	90	1.0	-	98.42	12.0	12.51	10.92	11.21	31.68	N
2	"	"	"	115	-	1.0	98.64	10.5	11.21	10.21	12.11	32.79	N
3	"	"	"	125	1.0	1.0	97.54	13.5	10.28	9.68	10.41	31.18	N
4	"	"	"	155	5.0	-	98.85	10.6	10.82	10.75	11.41	32.92	N
5	"	"	"	150	-	5.0	99.36	9.6	11.69	11.02	12.81	34.58	N
6	"	"	"	175	5.0	5.0	99.16	10.1	11.85	11.01	12.57	34.83	N
7	"	"	"	175	7.6	-	99.49	8.4	11.94	11.58	13.14	37.26	N
8	"	"	"	195	-	5.1	99.21	11.0	11.68	10.69	12.32	34.91	N
9	"	"	"	195	7.6	5.1	99.68	9.2	13.24	11.82	12.62	35.62	N
10	"	"	"	300	22.5	-	94.92	16.8	6.54	4.64	5.82	2.83	S
11	"	"	"	340	-	6.5	97.92	10.8	10.41	9.49	9.86	20.45	N
12	"	"	"	340	10.8	6.5	94.86	15.8	5.19	5.06	6.24	5.92	S
13	1:9	45	7 - 15	-	-	-	98.32	13.7	13.02	10.22	10.95	27.92	A

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Permanent magnets were also made in accordance with this invention (Samples YB-1, YB-2 and YB-3) from powder having the following base composition in weight percent: Nd - 35.77%, B - 1.11%, Dy - 0.57%.  
 5 Pr - 0.55% and Fe - balance. The powder utilized was passivated by a combination of 92% N<sub>2</sub> and 8% CO<sub>2</sub>. These samples were analyzed for nitrogen and carbon bulk content in weight % and surface concentration in atomic  
 10 %. Magnetic properties and sintered density of the samples were measured. Sample AE-1 made by conventional powder metallurgy technique was also analyzed for comparative purposes. The results are reported in Table II below.

TABLE II

15	SAMPLE NO.	YB-1	YB-2	YB-3	AE-1
	Bulk Nitrogen (Weight %)	0.0550	0.0539	0.0541	0.0464
	Bulk Carbon (Weight %)	0.0756	0.0741	0.0760	0.0765
20	Surface Nitrogen (Atomic %)	1.5	1.5	1.5	---
	Surface Carbon (Atomic %)	*	*	*	---
25	H <sub>c</sub> (kOe)	10.81	10.62	10.75	10.4
	B <sub>r</sub> (kG)	11.59	11.31	11.37	11.2
	H <sub>ci</sub> (kOe)	14.19	13.75	13.50	13.1
30	(BH) <sub>max</sub> (MGOe)	31.52	30.40	30.56	29.4
	Sintered Density (g/cm <sup>3</sup> )	7.52	7.53	7.51	7.29

\* - Below Level of Detection of AES

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Magnetic property results for Samples YB-1, YB-2, YB-3 and AE-1 are further illustrated in FIGS. 20, 21, 22 and 23 respectively.

5        Additionally, sintered permanent magnets of the  $\text{Nd}_2\text{Fe}_{14}\text{B}$  type were made in accordance with this invention (Samples D-1, D-2, D-3 and D-4) from alloy crushed in a passivating gas, the alloy having the following base composition in weight percent: Nd - 35.4%, B - 1.2% and Fe - balance. Sintered permanent  
10       magnets of the  $\text{SmCo}_5$  type were also made in accordance with this invention (Samples D-5, D-6 and D-7) from alloy crushed in a passivating gas, the alloy having the following base composition in weight percent: Sm - 37% and Co - balance. The alloy utilized was crushed  
15       in an attritor in a continuous flow of  $\text{CO}_2$  for Samples D-1, D-2, D-3, D-5 and D-6, and  $\text{N}_2$  for Samples D-4 and D-7, at a pressure of about 13.5 psig at ambient temperature to a particle size range of about 0.2  
20       microns to 100 microns. The powder was removed from the attritor, compacted without a protective atmosphere, and then sintered. Samples D-5, D-6 and D-7 were also annealed at  $900^\circ\text{C}$  for 1 hour. However, the magnetic properties of all the sintered magnet samples would be enhanced by additional heat treatment as can  
25       be appreciated by those skilled in the art. The density and magnetic properties were measured and the results are reported in Table III below and FIGS. 24-27.



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TABLE III

SAMPLE NO.	D-1	D-2	D-3	D-4	D-5	D-6	D-7
Crushing Time (min)	10	10	15	10	15	15	15
$P_a/P_b$	1:10	1:10	1:10	1:10	1:10	1:10	1:10
Passivating Gas	CO <sub>2</sub>	CO <sub>2</sub>	CO <sub>2</sub>	N <sub>2</sub>	CO <sub>2</sub>	CO <sub>2</sub>	N <sub>2</sub>
Time Delay Between Crushing and Compacting	None	14 days	None	None	None	3 days	3 days
$D_p$ ( $\mu\text{m}$ )	6	6	6	6	1.5	1.5	1.5
Pressure ( $\text{T}/\text{cm}^2$ )	5.0	5.0	5.0	5.0	3.3	3.3	5.0
Density ( $\text{g}/\text{cm}^3$ )	7.27	7.25	7.36	7.24	8.34	8.41	8.37
$H_{cl}$ (kOe)	5.96	5.97	6.17	6.06	23.04	20.15	24.15
$H_c$ (kOe)	5.59	5.52	5.86	5.32	6.75	6.54	7.01
$B_r$ (kG)	12.0	12.09	11.44	11.84	7.98	7.64	7.85
$(BH)_{\text{max}}$ (MGoe)	26.7	26.47	25.26	23.22	15.75	15.42	15.55

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Furthermore, sintered permanent magnets of the  $\text{Nd}_2\text{Fe}_{14}\text{B}$  type were made in accordance with this invention (Samples W-1, W-2, W-3 and W-4) from powder crushed in water, the powder having the following base composition in weight percent: Nd - 35.4%, B - 1.11% and Fe - balance. Sintered permanent magnets of the  $\text{SmCo}_5$  type were also made in accordance with this invention (Samples W-5, W-6 and W-7) from powder crushed in water, the powder having the following base composition in weight percent: Sm - 37% and Co - balance. For Samples W-1 through W-7, the powder utilized was wet compacted at a pressure of about 4 T/cm<sup>2</sup>. Following compaction, the samples were placed in a vacuum furnace, the pressure was reduced to about 10<sup>-5</sup> Torr, and the samples were then heated to approximately 200°C for about 2 hours. The samples were then heated up from about 200°C to 760°C and, during this procedure, passivating gas was injected into the vacuum furnace chamber to passivate the compact samples when the temperature was from about 250°C to 280°C. The passivating gas utilized for Samples W-1, W-3, and W-5 was CO<sub>2</sub>. The passivating gas utilized for Samples W-4 and W-7 was N<sub>2</sub>, and a combination of about 91% CO<sub>2</sub> and 9% N<sub>2</sub> was utilized for Samples W-2 and W-6. Thereafter, each compact sample was sintered and analyzed for magnetic properties. However, the sintered magnet samples were not heat treated, but the magnetic properties of the samples would be enhanced by heat treatment after sintering as can be appreciated by those skilled in the art. The results are reported in Table IV below and FIGS. 28-31.

TABLE IV

SAMPLE NO.	Crushing Time (min)	W-1		W-2		W-3		W-4		W-5		W-6		W-7	
		1:10	CO <sub>2</sub>	1:10	CO <sub>2</sub> +N <sub>2</sub>	1:10	CO <sub>2</sub>	1:10	N <sub>2</sub>	1:10	CO <sub>2</sub>	1:10	CO <sub>2</sub> +N <sub>2</sub>	1:10	N <sub>2</sub>
5															
	P <sub>a</sub> /P <sub>b</sub>	1:10		1:10		1:10		1:10		1:10		1:10		1:10	
	Passivating Gas	CO <sub>2</sub>		CO <sub>2</sub> +N <sub>2</sub>		CO <sub>2</sub>		N <sub>2</sub>		CO <sub>2</sub>		CO <sub>2</sub> +N <sub>2</sub>		N <sub>2</sub>	
10	D <sub>p</sub> (μm)	~6		~6		~6		~6		~1.5		~1.5		~1.5	
	Pressure (T/cm <sup>2</sup> )	4.0		4.0		4.0		5.0		4.0		4.0		5.0	
	Density (g/cm <sup>3</sup> )	7.25		7.18		7.30		7.32		8.42		8.38		8.29	
15	H <sub>ci</sub> (kOe)	4.88		5.88		7.33		7.15		19.50		18.50		19.20	
	H <sub>c</sub> (kOe)	4.63		5.50		6.76		6.43		6.50		6.80		6.64	
20	B <sub>F</sub> (kG)	10.13		10.19		10.45		10.28		7.19		7.75		7.51	
	(BH) <sub>max</sub> (MGoe)	20.24		21.96		22.68		21.94		15.64		15.98		15.04	

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5       While this invention has been described with respect to particular embodiments thereof, it is apparent that numerous other forms and modifications of this invention will be obvious to those skilled in the art. The appended claims and this invention generally should be construed to cover all such obvious forms and modifications which are within the true spirit and scope of the present invention.

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CLAIMS

What is claimed is:

1. A process for producing a rare earth-containing material capable of being formed into a permanent magnet comprising crushing a rare earth-containing alloy and treating the alloy with a passivating gas at a temperature below the phase transformation temperature of the alloy.  
5
2. The process of Claim 1 wherein the passivating gas is nitrogen, carbon dioxide or a combination of nitrogen and carbon dioxide.  
10
3. A passivated rare earth-containing alloy product capable of being formed into a permanent magnet produced by the process defined in Claim 1.
4. A process for producing a rare earth-containing material capable of being formed into a permanent magnet, which comprises crushing a rare earth-containing alloy and contacting such alloy, after it has been brought into particulate form, with a passivating gas.  
15  
20
5. A process for producing a rare earth-containing powder comprising crushing a rare earth-containing alloy in a passivating gas at a temperature from ambient temperature to a temperature below the phase transformation temperature of the material.  
25
6. The process of Claim 5 wherein the passivating gas is nitrogen, carbon dioxide or a combination of nitrogen and carbon dioxide.
7. The process of Claim 5 wherein the alloy comprises, in atomic percent of the overall composition, from about 12% to about 24% of at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium,  
30

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samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and the balance iron.

5        8. The process of Claim 5 wherein the alloy comprises  $RM_5$  or  $R_2M_{17}$ , wherein R is at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, 10        yttrium, and scandium, and M is at least one metal selected from the group consisting of Co, Fe, Ni and Mn.

15        9. The process of Claim 5 wherein the alloy is crushed to a particle size of from about 0.05 microns to about 100 microns.

10. The process of Claim 9 wherein the alloy is crushed to a particle size of from 1 micron to 40 microns.

20        11. The process of Claim 6 wherein the resultant powder has a surface concentration of nitrogen of from about 0.4 to about 26.8 atomic percent.

25        12. The process of Claim 6 wherein the resultant powder has a surface concentration of carbon of from about 0.02 to about 15 atomic percent.

30        13. A process for producing a rare earth-containing powder comprising: crushing a rare earth-containing alloy in a passivating gas for about 1 minute to about 60 minutes at a temperature from about 20°C to about 580°C to a particle size of from about 0.05 microns to about 100 microns, said alloy comprising, in atomic percent of the overall composition, from about 12% to about 24% of at least one rare earth element selected from the group

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consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about  
5 28% boron and the balance iron.

14. The process of Claim 13 wherein the passivating gas is nitrogen, carbon dioxide or a combination of nitrogen and carbon dioxide.

15. The process of Claim 13 wherein the rare  
10 earth-containing alloy is crushed to a particle size of from 1 micron to 40 microns.

16. The process of Claim 4 wherein the resultant powder has a surface concentration of nitrogen of from about 0.4 to about 26.8 atomic  
15 percent.

17. The process of Claim 16 wherein the resultant powder has a surface concentration of nitrogen of 0.4 to 10.8 atomic percent.

18. The process of Claim 14 wherein the  
20 resultant powder has a surface concentration of carbon of from about 0.02 to about 15 atomic percent.

19. The process of Claim 18 wherein the resultant powder has a surface concentration of carbon of from 0.5 to 6.5 atomic percent.

25 20. A process for producing a permanent magnet comprising:

a) crushing a rare earth-containing alloy in a passivating gas for about 1 minute to about 60 minutes at a temperature from about 20°C to about 580°C  
30 to a particle size of from about 0.05 microns to about 100 microns, said alloy comprising, in atomic percent of the overall composition, of from about 12% to about 24% of at least one rare earth element selected from the group consisting of neodymium, praseodymium,

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lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and the balance iron;

5

b) compacting the crushed alloy material;

c) sintering the compacted alloy material at a temperature from 900°C to 1200°C inclusive; and

d) heat treating the sintered material at a temperature from 200°C to 1050°C inclusive.

10

21. The process of Claim 20 wherein the passivating gas is nitrogen, carbon dioxide or a combination of nitrogen and carbon dioxide.

15

22. The process of Claim 20 wherein the rare earth-containing alloy is crushed to particle size of from 1 micron to 40 microns.

23. The process of Claim 21 wherein the resultant permanent magnet has a surface concentration of nitrogen of from about 0.4 to about 26.8 atomic percent.

20

24. The process of Claim 23 wherein the resultant permanent magnet has a surface concentration of nitrogen of 0.4 to 10.8 atomic percent.

25

25. The process of Claim 21 wherein the resultant permanent magnet has a surface concentration of carbon of from about 0.02 to about 15 atomic percent.

30

26. The process of Claim 25 wherein the resultant permanent magnet has a surface concentration of carbon of from 0.5 to 6.5 atomic percent.

27. A process for producing a rare earth-containing powder comprising crushing an alloy in water, drying the crushed alloy material at a temperature below the phase transformation temperature of the material, and treating the crushed alloy



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material with a passivating gas at a temperature from ambient temperature to a temperature below the phase transformation temperature of the material.

28. The process of Claim 27 wherein the  
5 passivating gas is nitrogen.

29. The process of Claim 27 wherein the  
passivating gas is carbon dioxide.

30. The process of Claim 27 wherein the  
10 passivating gas is a combination of nitrogen and carbon dioxide.

31. The process of Claim 27, 28, 29 or 30  
wherein the alloy comprises, in atomic percent of the  
overall composition, from about 12% to about 24% of at  
least one rare earth element selected from the group  
15 consisting of neodymium, praseodymium, lanthanum,  
cerium, terbium, dysprosium, holmium, erbium, europium,  
samarium, gadolinium, promethium, thulium, ytterbium,  
lutetium, yttrium, and scandium, from about 2% to about  
28% boron and the balance iron.

32. The process of Claim 27, 28, 29 or 30  
20 wherein the alloy comprises  $RM_5$  or  $R_2M_{17}$ , wherein R is  
at least one rare earth element selected from the group  
consisting of neodymium, praseodymium, lanthanum,  
cerium, terbium, dysprosium, holmium, erbium, europium,  
25 samarium, gadolinium, promethium, thulium, ytterbium,  
lutetium, yttrium, and scandium, and M is a  
metal selected from the group consisting of Co, Fe, Ni  
and Mn.

33. The process of Claim 27 wherein the alloy  
30 is crushed in water to a particle size of from about  
0.05 microns to about 100 microns.

34. The process of Claim 33 wherein the alloy  
is crushed in water to a particle size of from 1 micron

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to 40 microns.

35. The process of Claim 27 wherein the crushed alloy material is vacuum dried or dried with an inert gas.

5           36. The process of Claim 35 wherein the inert gas is selected from the group consisting of argon and helium.

10           37. The process of Claim 28 or 30 wherein the resultant powder has a nitrogen surface concentration of from about 0.4 to about 26.8 atomic percent.

          38. The process of Claim 29 or 30 wherein the resultant powder compact has a carbon surface concentration of from about 0.02 to about 15 atomic percent.

15           39. A process for producing a rare earth-containing powder comprising: crushing a rare earth-containing alloy in water to a particle size of from about 0.05 microns to about 100 microns, said alloy comprising, in atomic percent of the overall  
20 composition, from about 12% to about 24% of at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium,  
25 lutetium, yttrium, and scandium, from about 2% to about 28% boron and the balance iron; drying the crushed alloy material at a temperature below the phase transformation temperature of the material; and  
30 treating the crushed alloy material with a passivating gas from about 1 minute to about 60 minutes at a temperature from about 20°C to about 580°C.

          40. The process of Claim 39 wherein the passivating gas is nitrogen.

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41. The process of Claim 39 wherein the passivating gas is carbon dioxide.

42. The process of Claim 39 wherein the passivating gas is a combination of nitrogen and carbon dioxide.

43. The process of Claim 39 wherein the rare earth-containing alloy is crushed in water to a particle size of from 1 micron to 40 microns.

44. The process of Claim 39 wherein the crushed alloy material is vacuum dried or dried with an inert gas.

45. The process of Claim 40 or 42 wherein the resultant powder has a nitrogen surface concentration of from about 0.4 to about 26.8 atomic percent.

46. The process of Claim 45 wherein the resultant powder has a nitrogen surface concentration of 0.4 to 10.8 atomic percent.

47. The process of Claim 41 or 42 wherein the resultant powder has a carbon surface concentration of from about 0.02 to about 15 atomic percent.

48. The process of Claim 47 wherein the resultant powder has a carbon surface concentration of from 0.5 to 6.5 atomic percent.

49. A non-pyrophoric rare earth-containing powder comprising, in atomic percent of the overall composition, from about 12% to about 24% of at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and at least 52% iron, and further having a nitrogen surface concentration of from about 0.4 to

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about 26.8 atomic percent.

50. The powder of Claim 49 wherein the rare earth element is neodymium and/or praseodymium.

5 51. The powder of Claim 49 wherein the nitrogen surface concentration is from 0.4 to 10.8 atomic percent.

10 52. A non-pyrophoric rare earth-containing powder comprising, in atomic percent of the overall composition, from about 12% to about 24% of at least one rare earth element, selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 15 28% boron, and at least 52% iron, and further having a carbon surface concentration of from about 0.02 to about 15 atomic percent.

53. The powder of Claim 52 wherein the rare earth element is neodymium and/or praseodymium.

20 54. The powder of Claim 52 wherein the carbon surface concentration is from 0.5 to 6.5 atomic percent.

55. A process for producing a permanent magnet comprising:

25 a) crushing a rare earth-containing alloy in water to a particle size of from about 0.05 microns to about 100 microns, said alloy comprising, in atomic percent of the overall composition, of from about 12% to about 24% of at least one rare earth element  
30 selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and

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scandium, from about 2% to about 28% boron and the balance iron;

5           b) drying the crushed alloy material at a temperature below the phase transformation temperature of the material;

          c) treating the crushed alloy material with a passivating gas from about 1 minute to about 60 minutes at a temperature from about 20°C to about 580°C;

          d) compacting the crushed alloy material;

10           e) sintering the compacted alloy material at a temperature from 900°C to 1200°C inclusive; and

          f) heat treating the sintered material at a temperature from 200°C to 1050°C inclusive.

15           56. The process of Claim 55 wherein the passivating gas is nitrogen.

          57. The process of Claim 55 wherein the passivating gas is carbon dioxide.

20           58. The process of Claim 55 wherein the passivating gas is a combination of nitrogen and carbon dioxide.

          59. The process of Claim 55 wherein the rare earth-containing alloy is crushed in water to particle size of from 1 micron to 40 microns.

25           60. The process of Claim 55 wherein the crushed alloy material is vacuum dried or dried with an inert gas selected from the group consisting of argon and helium at a pressure below 760 torr.

30           61. The process of Claim 56 or 58 wherein the resultant permanent magnet has a nitrogen surface concentration of from about 0.4 to about 26.8 atomic percent.

          62. The process of Claim 61 wherein the resultant permanent magnet has a nitrogen surface

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concentration of 0.4 to 10.8 atomic percent.

63. The process of Claim 57 or 58 wherein the resultant permanent magnet has a carbon surface concentration of from about 0.02 to about 15 atomic percent.

64. The process of Claim 63 wherein the resultant permanent magnet has a carbon surface concentration of from 0.5 to 6.5 atomic percent.

65. A process for producing a rare earth-containing powder compact comprising crushing a rare earth-containing alloy in water, compacting the crushed alloy material, drying the compacted alloy material at a temperature below the phase transformation temperature of the material, and treating the compacted alloy material with a passivating gas at a temperature from ambient temperature to a temperature below the phase transformation temperature of the material.

66. The process of Claim 65 wherein the passivating gas is nitrogen, carbon dioxide or a combination of nitrogen and carbon dioxide.

67. The process of Claim 65 wherein the alloy comprises, in atomic percent of the overall composition, from about 12% to about 24% of at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and the balance iron.

68. The process of Claim 65 wherein the alloy comprises  $RM_5$  or  $R_2M_{17}$ , wherein R is at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium,

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dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, and M is at least one metal selected from the group consisting of Co, Fe, Ni and Mn.

69. The process of Claim 65 wherein the alloy is crushed in water to a particle size of from about 0.05 microns to about 100 microns.

70. The process of Claim 69 wherein the alloy is crushed in water to a particle size of from 1 micron to 40 microns.

71. The process of Claim 65 wherein the compacted alloy material is vacuum dried or dried with an inert gas.

72. The process of Claim 71 wherein the inert gas is selected from the group consisting of argon and helium.

73. The process of Claim 66 wherein the resultant powder compact has a surface concentration of nitrogen of from about 0.4 to about 26.8 atomic percent.

74. The process of Claim 66 wherein the resultant powder compact has a surface concentration of carbon of from about 0.02 to about 15 atomic percent.

75. A process for producing a rare earth-containing powder compact comprising: crushing a rare earth-containing alloy in water to a particle size of from about 0.05 microns to about 100 microns, said alloy comprising, in atomic percent of the overall composition, from about 12% to about 24% of at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium,

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samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and the balance iron; compacting the wet crushed alloy material to form wet compacted material; 5 drying the compacted alloy material at a temperature below the phase transformation temperature of the material; and treating the compacted alloy material with a passivating gas for about 1 minute to about 60 minutes at a temperature from about 20°C to about 580°C.

10 76. The process of Claim 75 wherein the passivating gas is nitrogen, carbon dioxide or a combination of nitrogen and carbon dioxide.

15 77. The process of Claim 75 wherein the rare earth-containing alloy is crushed in water to a particle size of from 1 micron to 40 microns.

78. The process of Claim 75 wherein the compacted alloy material is vacuum dried or dried with an inert gas.

20 79. The process of Claim 76 wherein the resultant powder compact has a surface concentration of nitrogen of from about 0.4 to about 26.8 atomic percent.

25 80. The process of Claim 79 wherein the resultant powder compact has a surface concentration of nitrogen of 0.4 to 10.8 atomic percent.

81. The process of Claim 76 wherein the resultant powder compact has a surface concentration of carbon of from about 0.02 to about 15 atomic percent.

30 82. The process of Claim 81 wherein the resultant powder compact has a surface concentration of carbon of from 0.5 to 6.5 atomic percent.

83. A non-pyrophoric rare earth-containing powder compact comprising, in atomic percent of the



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overall composition, from about 12% to about 24% of at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and at least 52% iron, and further having a surface concentration of nitrogen of from about 0.4 to about 26.8 atomic percent.

10                   84. The powder compact of Claim 83 wherein the rare earth element is neodymium and/or praseodymium.

15                   85. The powder compact of Claim 83 wherein the surface concentration of nitrogen is from 0.4 to 10.8 atomic percent.

20                   86. A non-pyrophoric rare earth-containing powder compact comprising, in atomic percent of the overall composition, from about 12% to about 24% of at least one rare earth element, selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron, and at least 52% iron, and further having a surface concentration of carbon of from about 0.02 to about 15 atomic percent.

25                   87. The powder compact of Claim 86 wherein the rare earth element is neodymium and/or praseodymium.

30                   88. The powder compact of Claim 86 wherein the surface concentration of carbon is from 0.5 to 6.5 atomic percent.

89. A process for producing a permanent

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magnet comprising:

- 5 a) crushing a rare earth-containing alloy in water to a particle size of from about 0.05 microns to about 100 microns, said alloy comprising, in atomic percent of the overall composition, of from about 12% to about 24% of at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, 10 promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and the balance iron;
- b) compacting the crushed alloy material;
- 15 c) drying the compacted alloy material at a temperature below the phase transformation temperature of the material;
- d) treating the compacted alloy material with a passivating gas for about 1 minute to about 60 minutes at a temperature from about 20°C to about 580°C;
- 20 e) sintering the compacted alloy material at a temperature from 900°C to 1200°C inclusive; and
- f) heat treating the sintered material at a temperature from 200°C to 1050°C inclusive.
- 25 90. The process of Claim 89 wherein the passivating gas is nitrogen, carbon dioxide or a combination of nitrogen and carbon dioxide.
91. The process of Claim 89 wherein the rare earth-containing alloy is crushed in water to particle size of from 1 micron to 40 microns.
- 30 92. The process of Claim 89 wherein the compacted alloy material is vacuum dried or dried with an inert gas.
93. The process of Claim 90 wherein the resultant permanent magnet has a surface concentration

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of nitrogen of from about 0.4 to about 26.8 atomic percent.

94. The process of Claim 93 wherein the resultant permanent magnet has a surface concentration of nitrogen of 0.4 to 10.8 atomic percent.

95. The process of Claim 90 wherein the resultant permanent magnet has a surface concentration of carbon of from about 0.02 to about 15 atomic percent.

96. The process of Claim 95 wherein the resultant permanent magnet has a surface concentration of carbon of from 0.5 to 6.5 atomic percent.

97. An improved permanent magnet of the type comprised of, in atomic percent of the overall composition, from about 12% to about 24% of at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and at least 52% iron, wherein the improvement comprises a nitrogen surface concentration of from about 0.4 to about 26.8 atomic percent.

98. The permanent magnet of Claim 97 wherein the rare earth element is neodymium and/or praseodymium.

99. The permanent magnet of Claim 97 wherein the nitrogen surface concentration is from 0.4 to 10.8 atomic percent.

100. An improved permanent magnet of the type comprised of, in atomic percent of the overall composition, from about 12% to about 24% of at least one rare earth element selected from the group

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consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, from about 2% to about 28% boron and at least 52% iron, wherein the improvement comprises a carbon surface concentration of from about 0.02 to about 15 atomic percent.

101. The permanent magnet of Claim 100 wherein the rare earth element is neodymium and/or praseodymium.

102. The permanent magnet of Claim 100 wherein the carbon surface concentration is from 0.5 to 6.5 atomic percent.

103. An improved permanent magnet of the type comprised of  $RM_5$  or  $R_2M_{17}$ , wherein R is at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, and M is at least one metal selected from the group consisting of Co, Fe, Ni and Mn, wherein the improvement comprises a surface concentration of nitrogen of from about 0.4 to about 26.8 atomic percent.

104. An improved permanent magnet of the type comprised of  $RM_5$  or  $R_2M_{17}$ , wherein R is at least one rare earth element selected from the group consisting of neodymium, praseodymium, lanthanum, cerium, terbium, dysprosium, holmium, erbium, europium, samarium, gadolinium, promethium, thulium, ytterbium, lutetium, yttrium, and scandium, and M is at least one metal selected from the group consisting of Co, Fe, Ni and Mn, wherein the improvement comprises a surface concentration of carbon of from about 0.02 to about 15

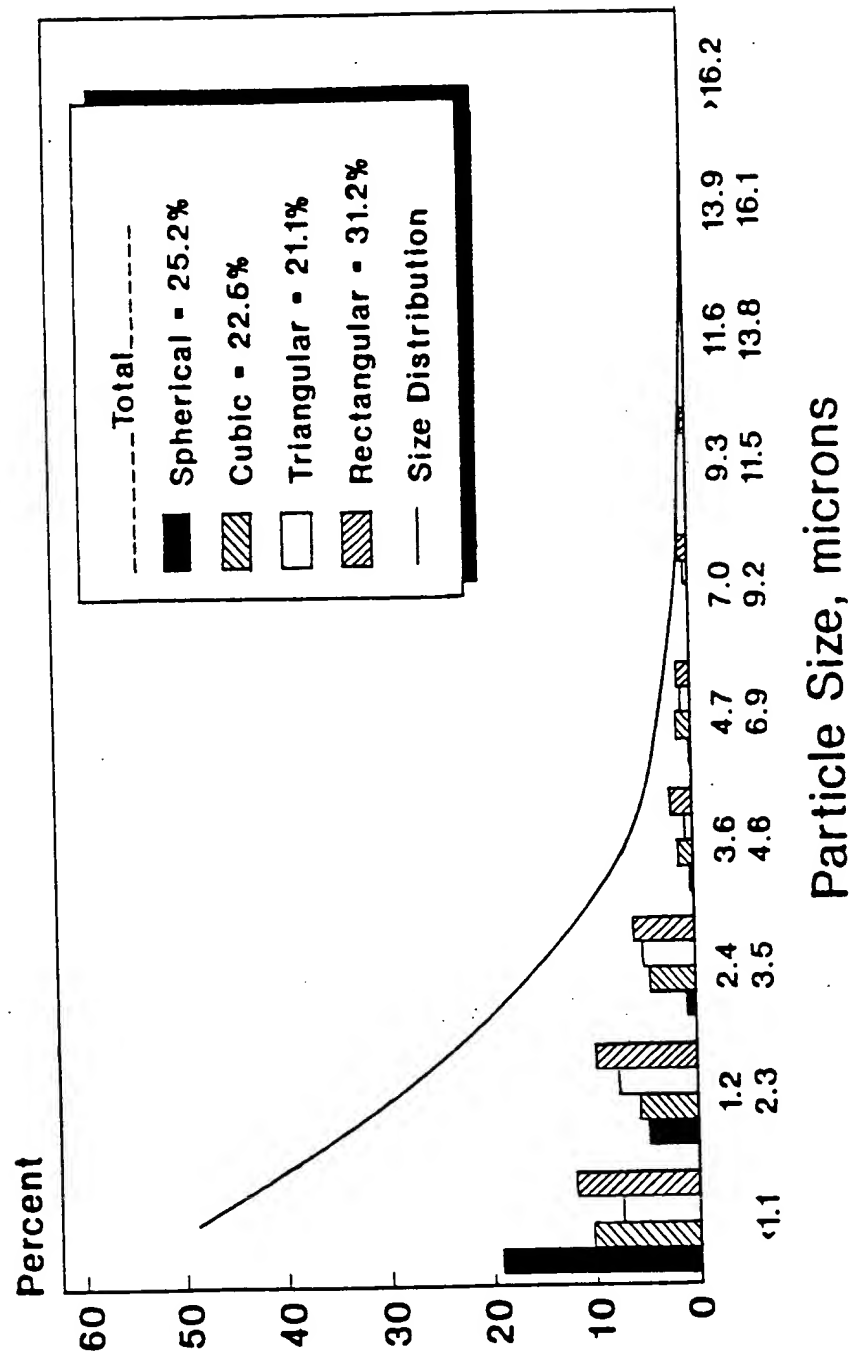
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atomic percent.

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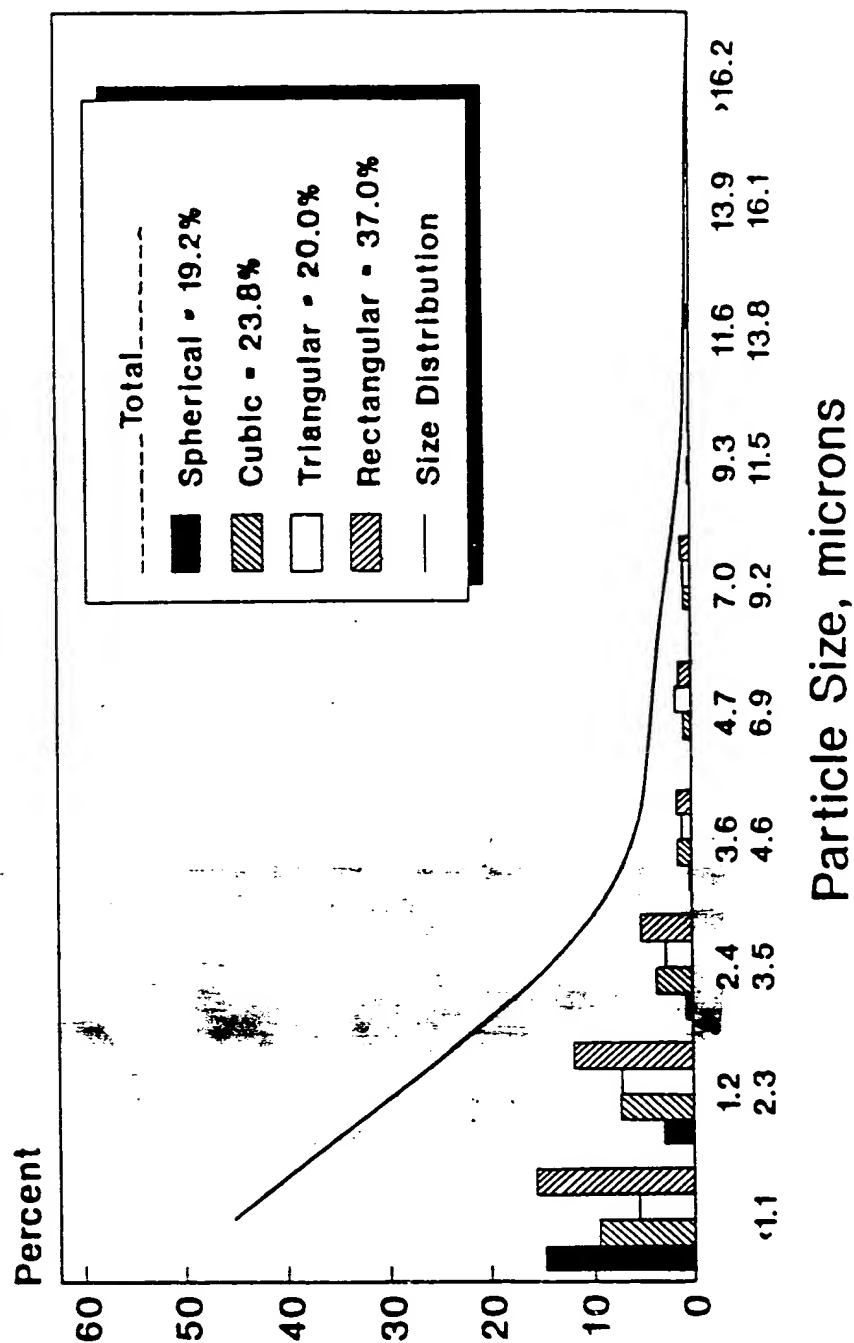
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FIG. 1



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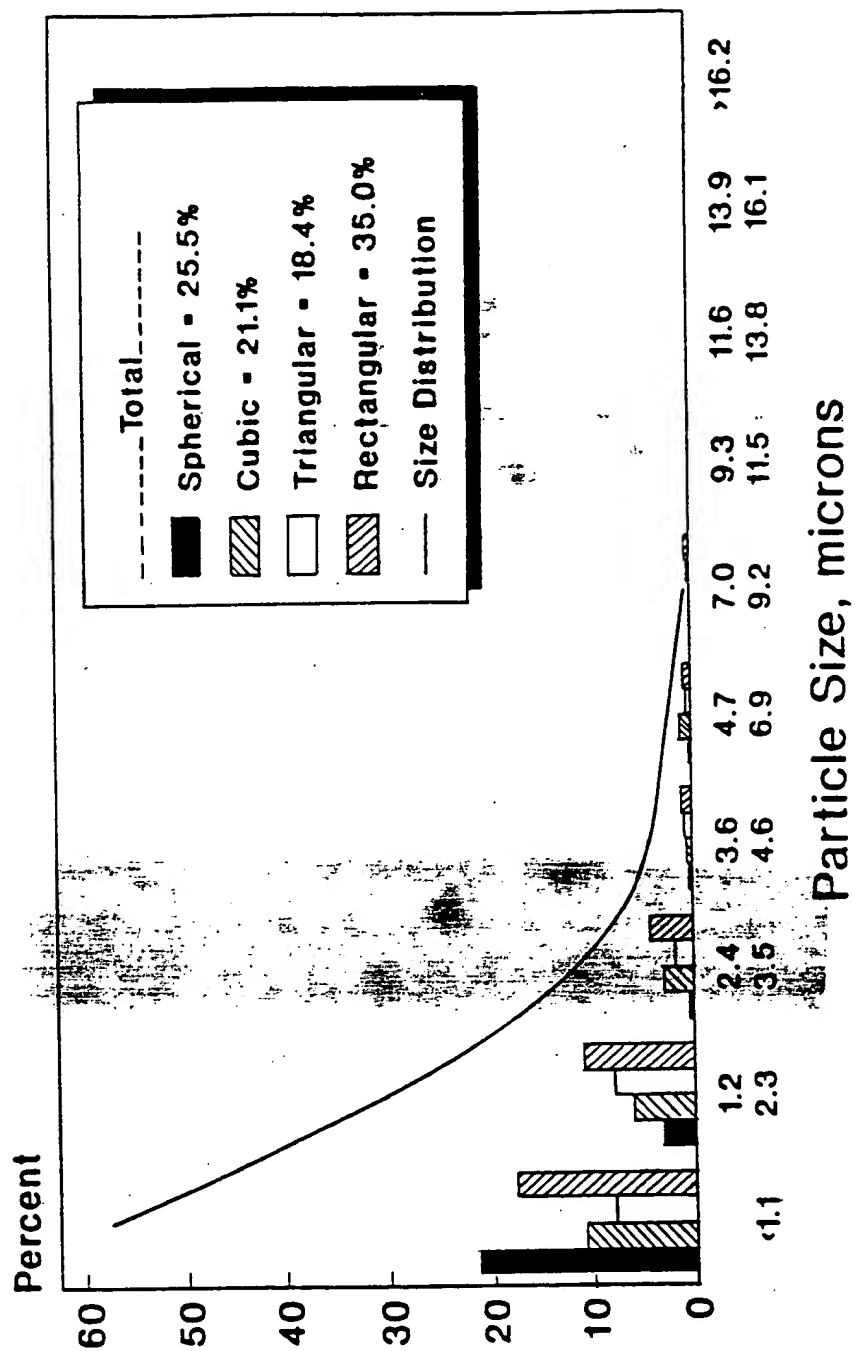
FIG. 2





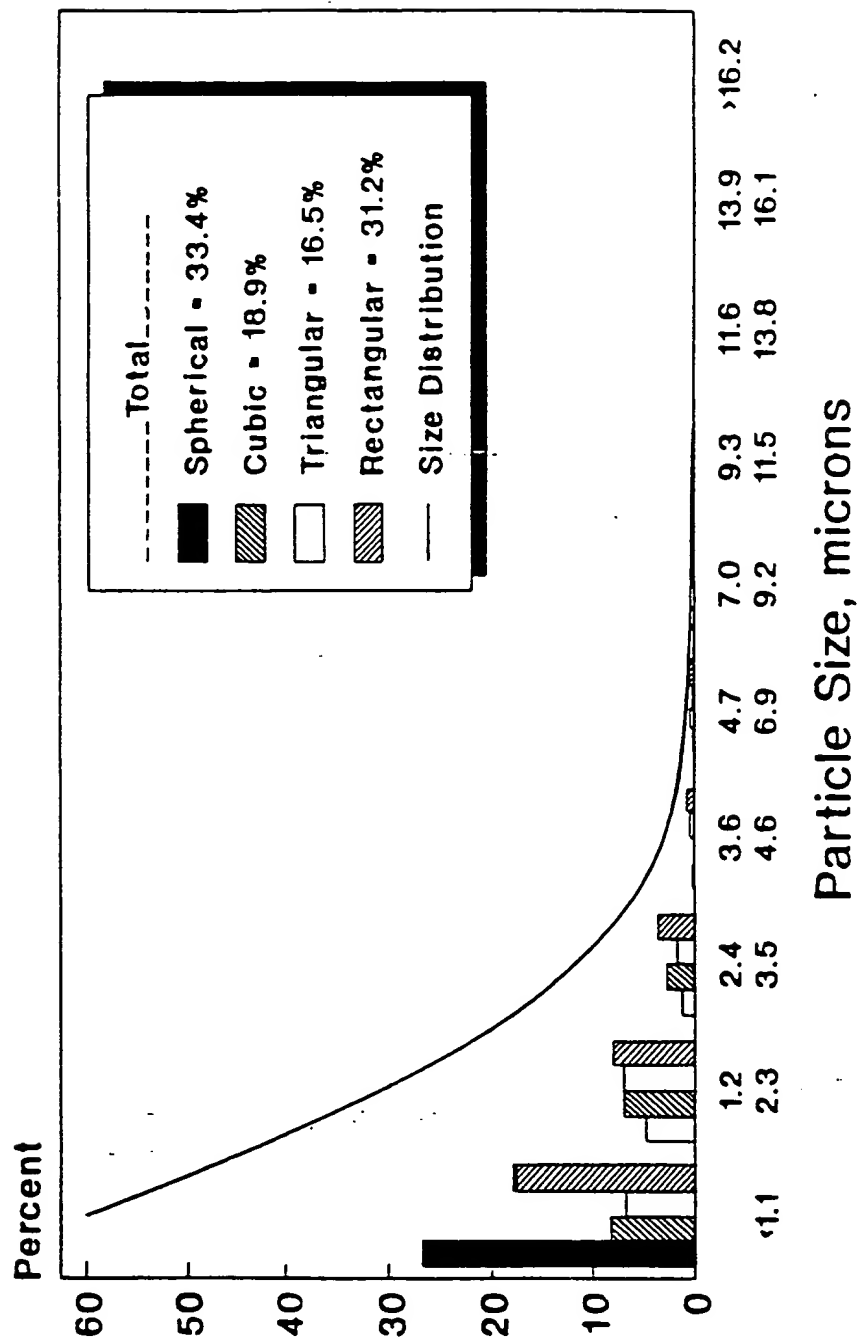
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FIG. 3



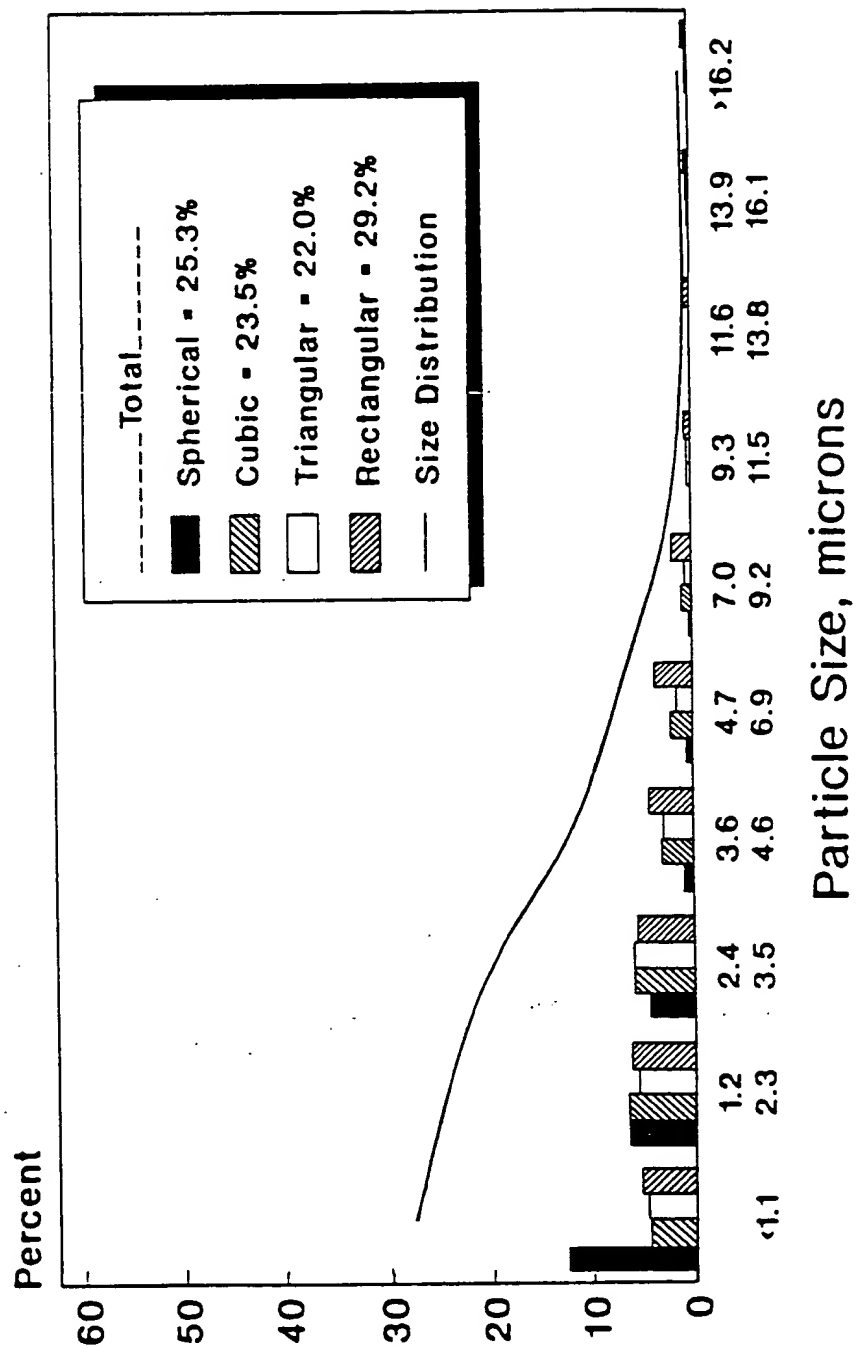
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FIG. 4



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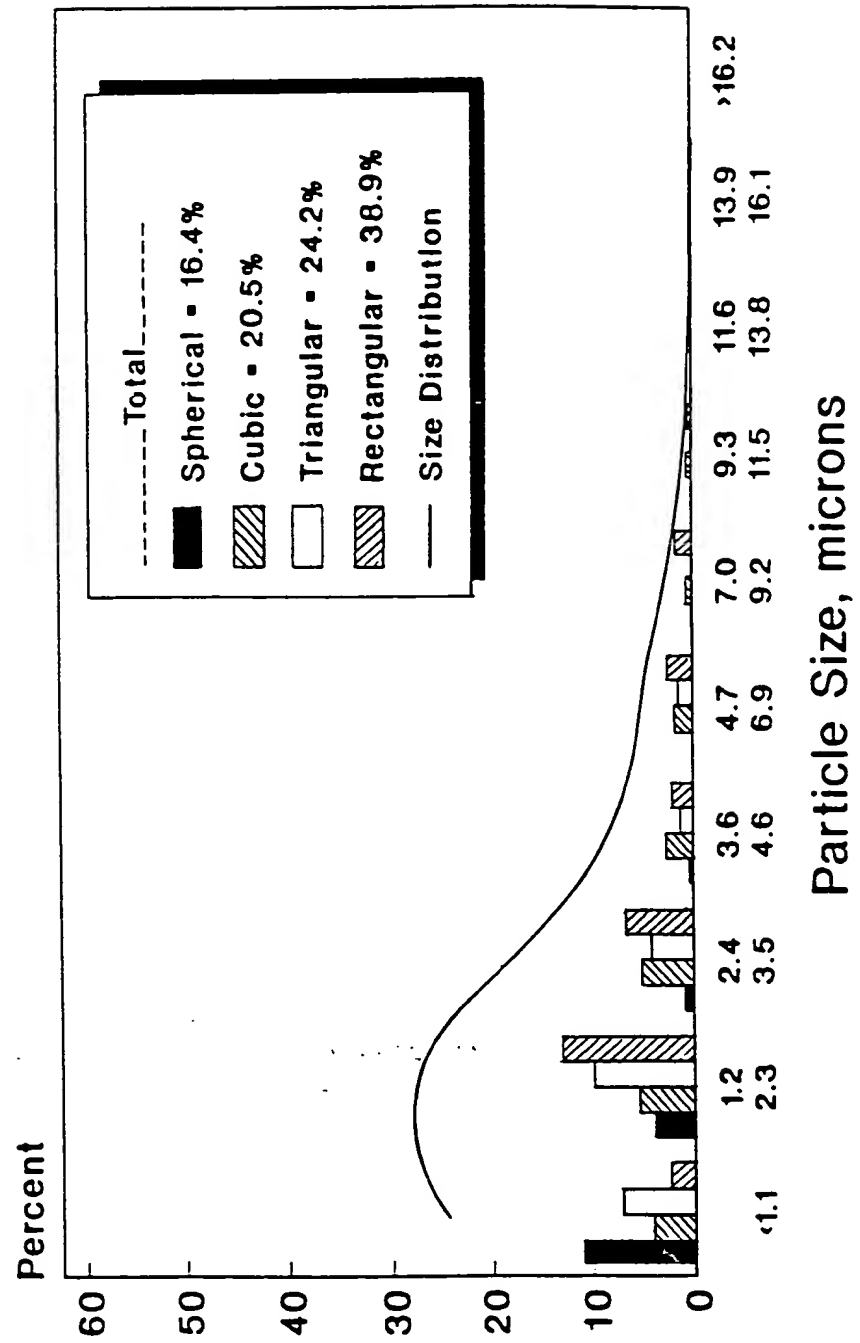
FIG. 5



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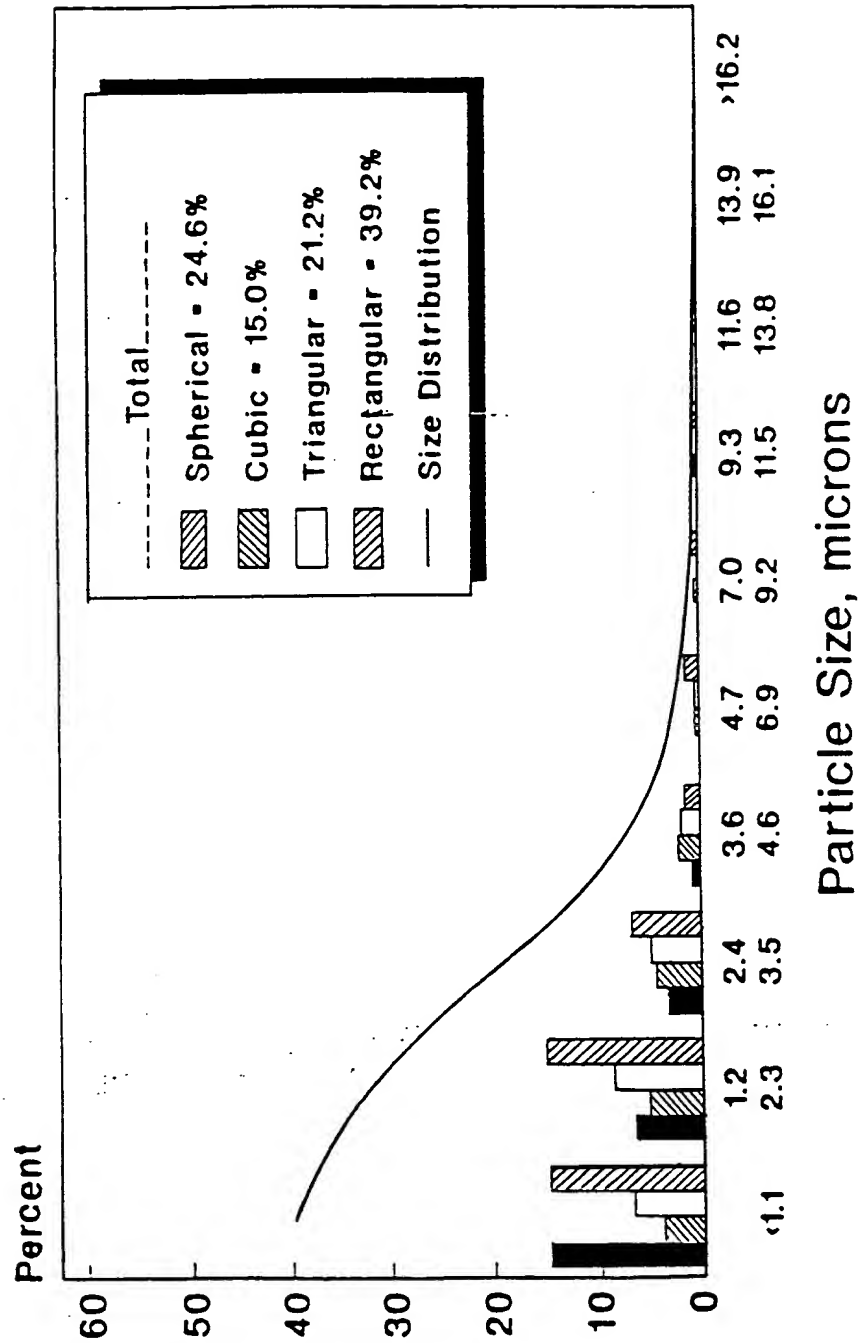
FIG. 6



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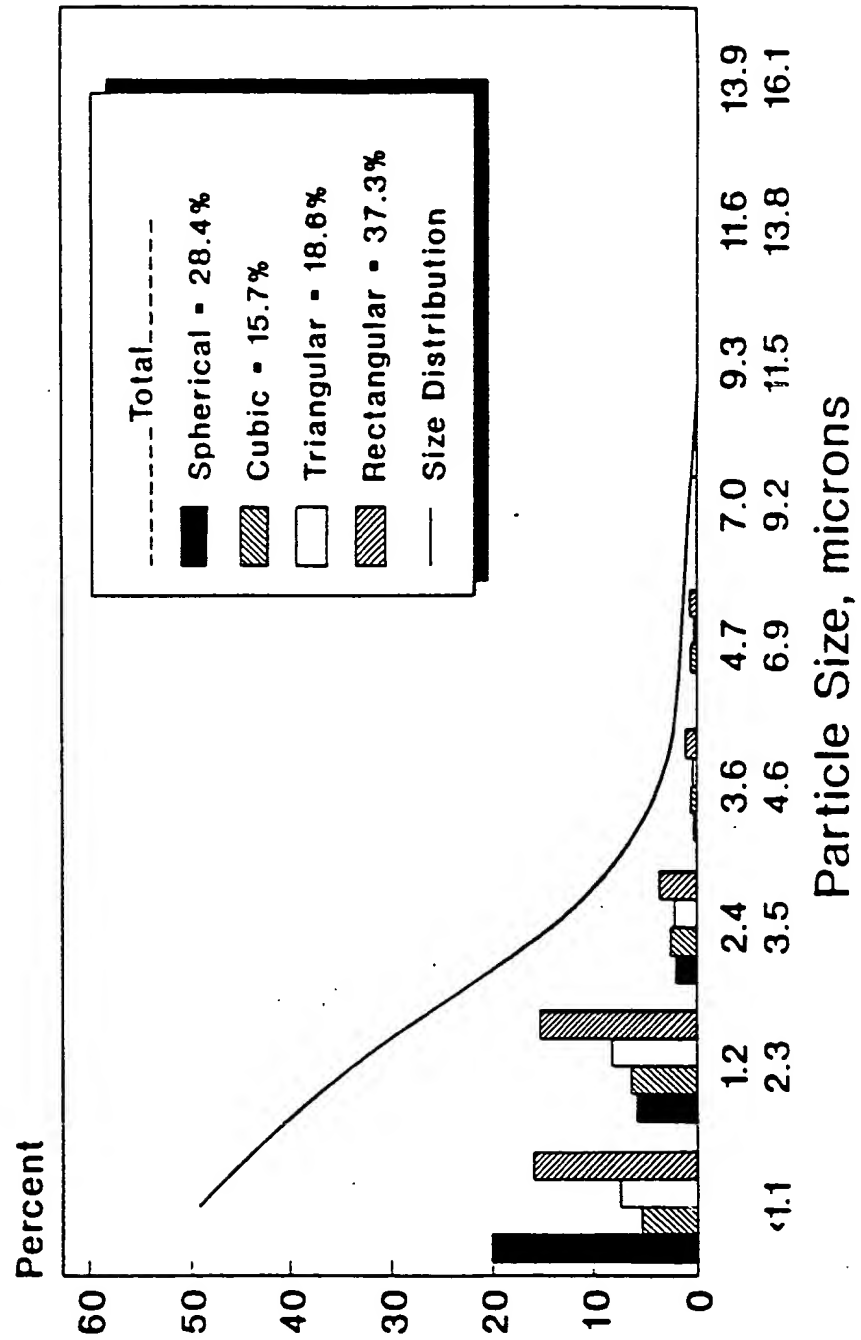
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FIG. 8



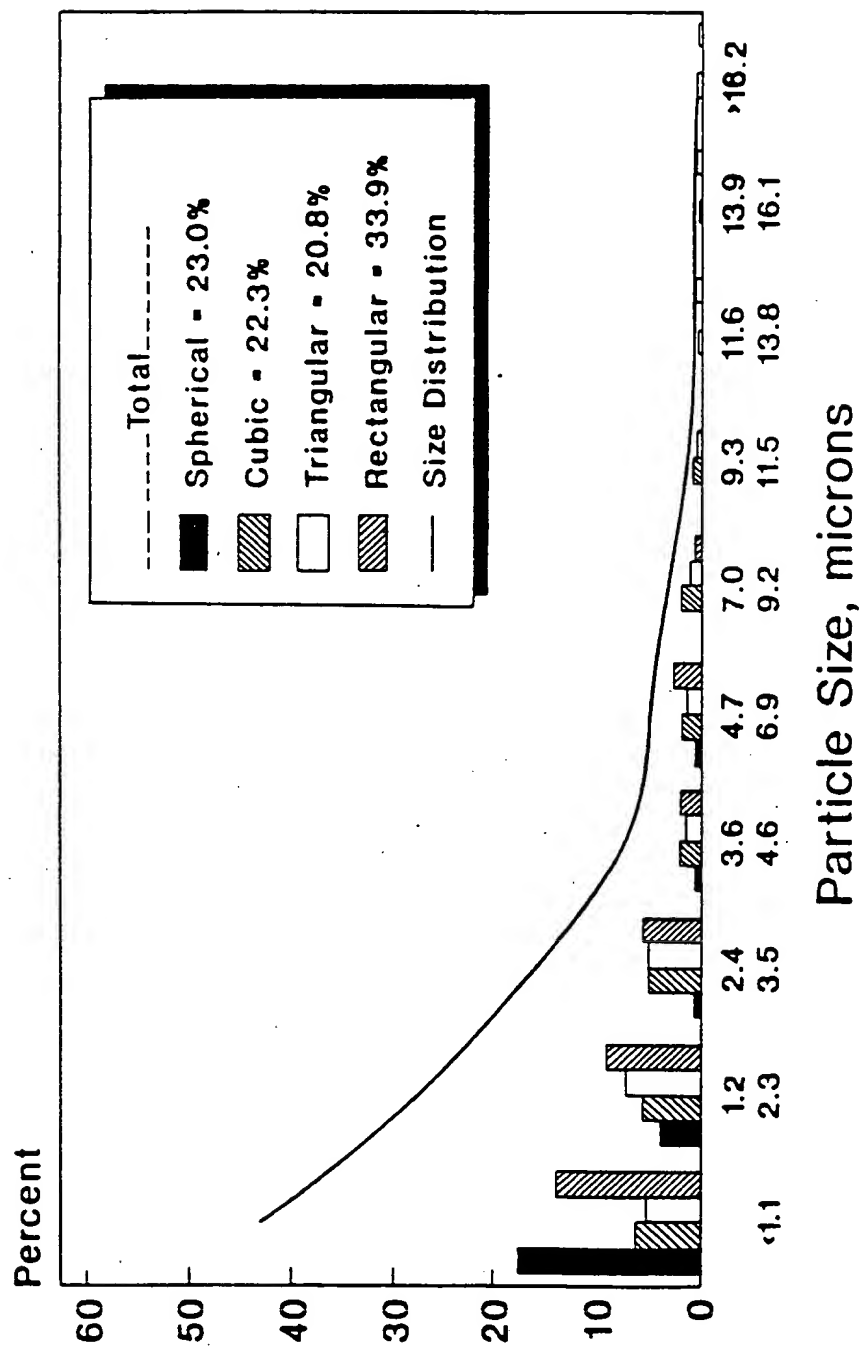
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FIG. 7



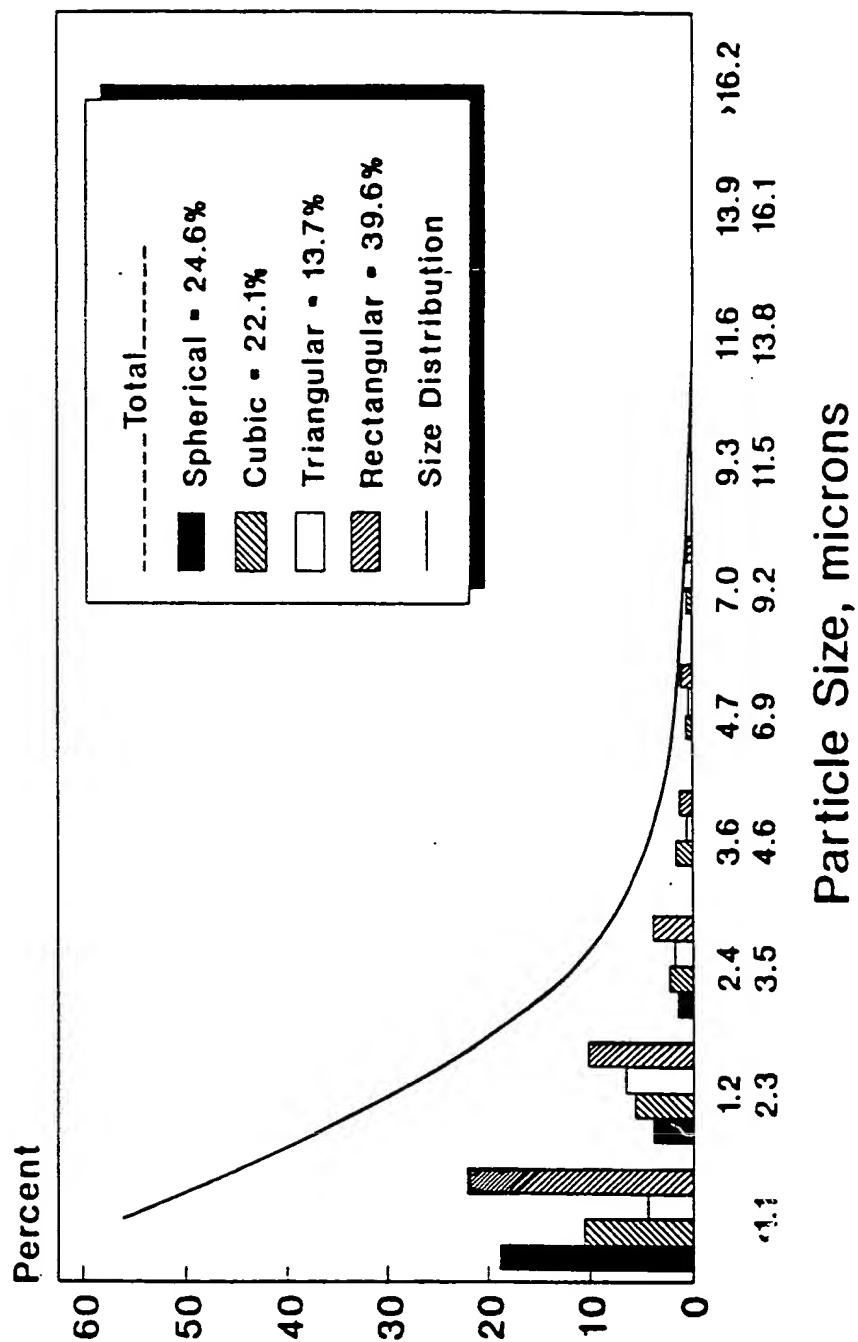
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FIG. 9



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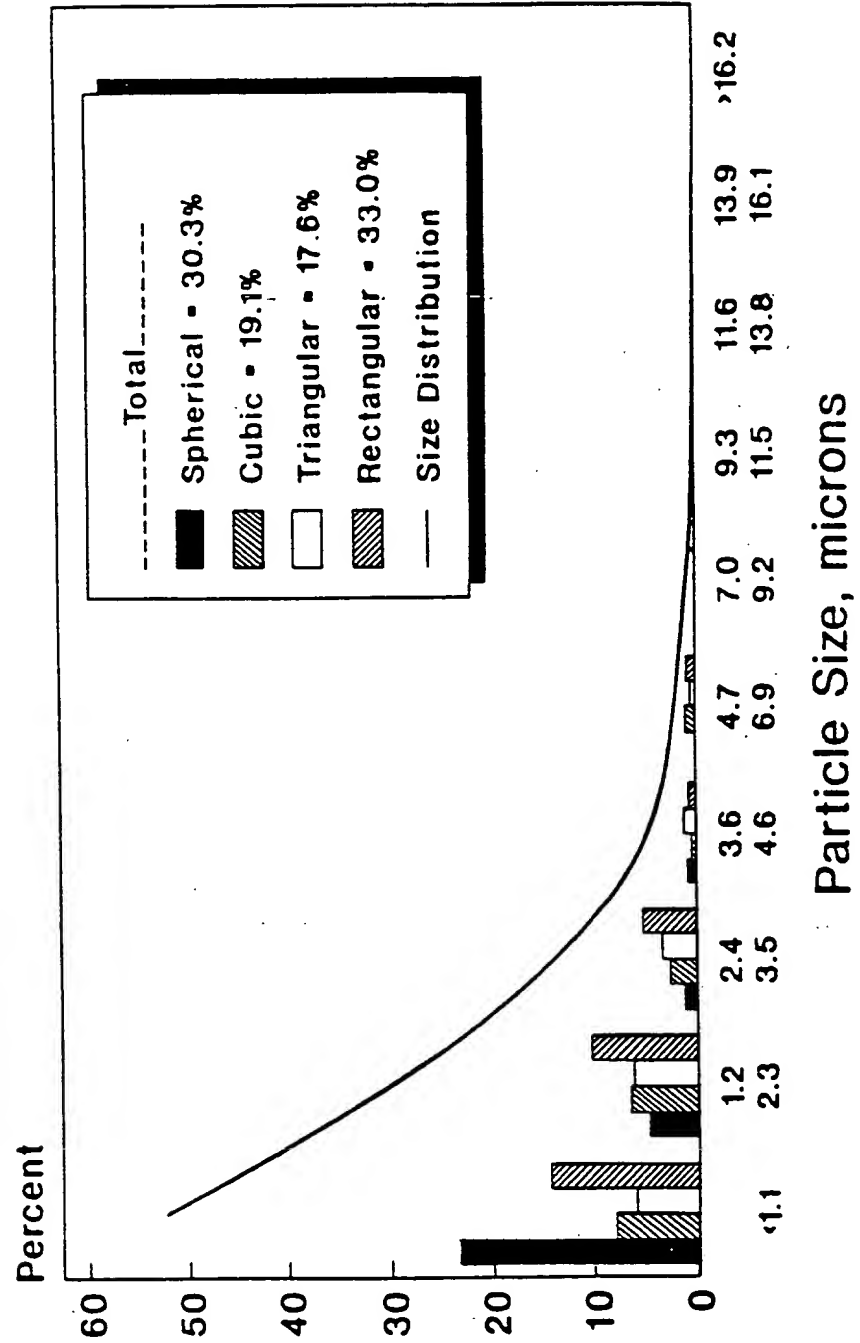
FIG.10





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FIG. 11



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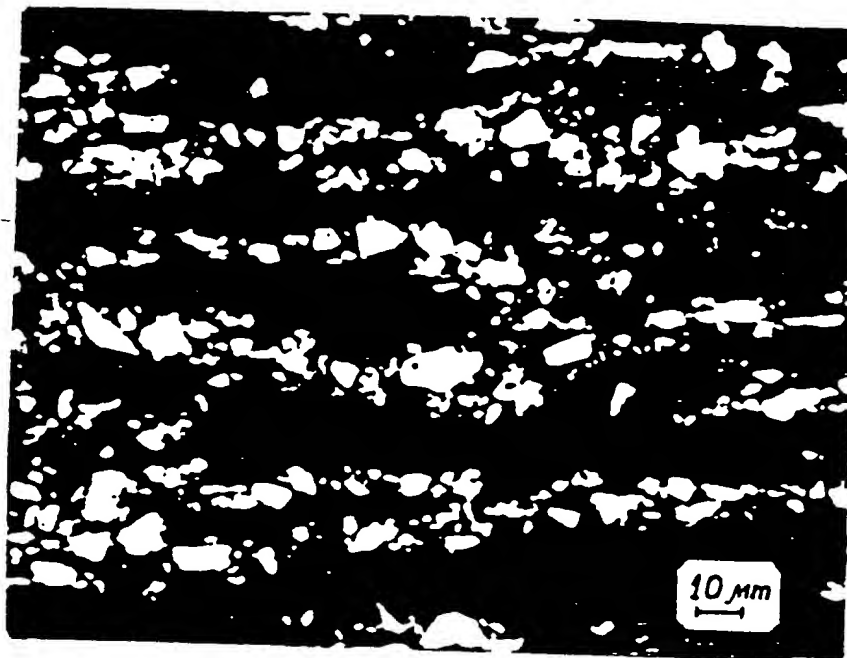


FIG. 12

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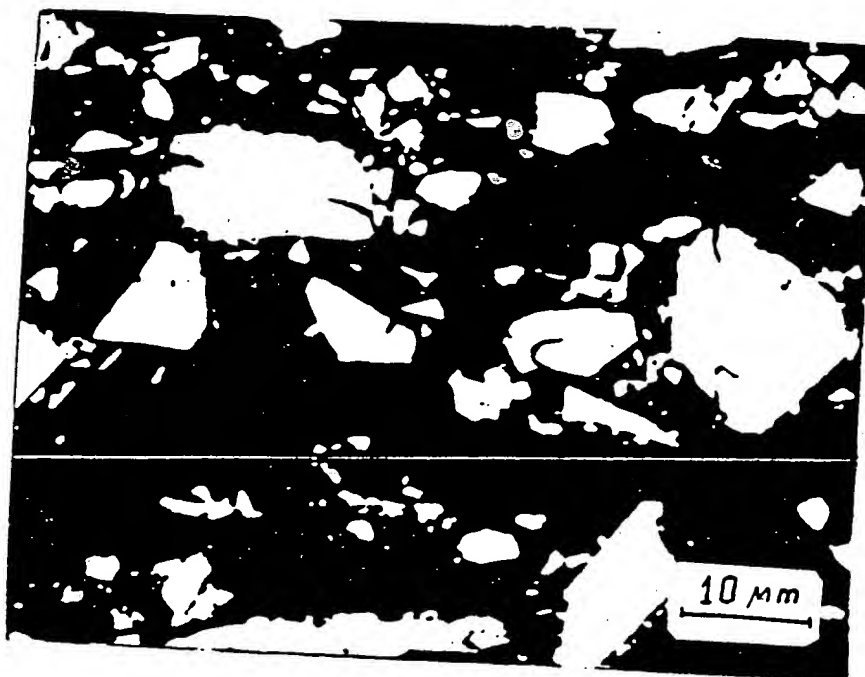


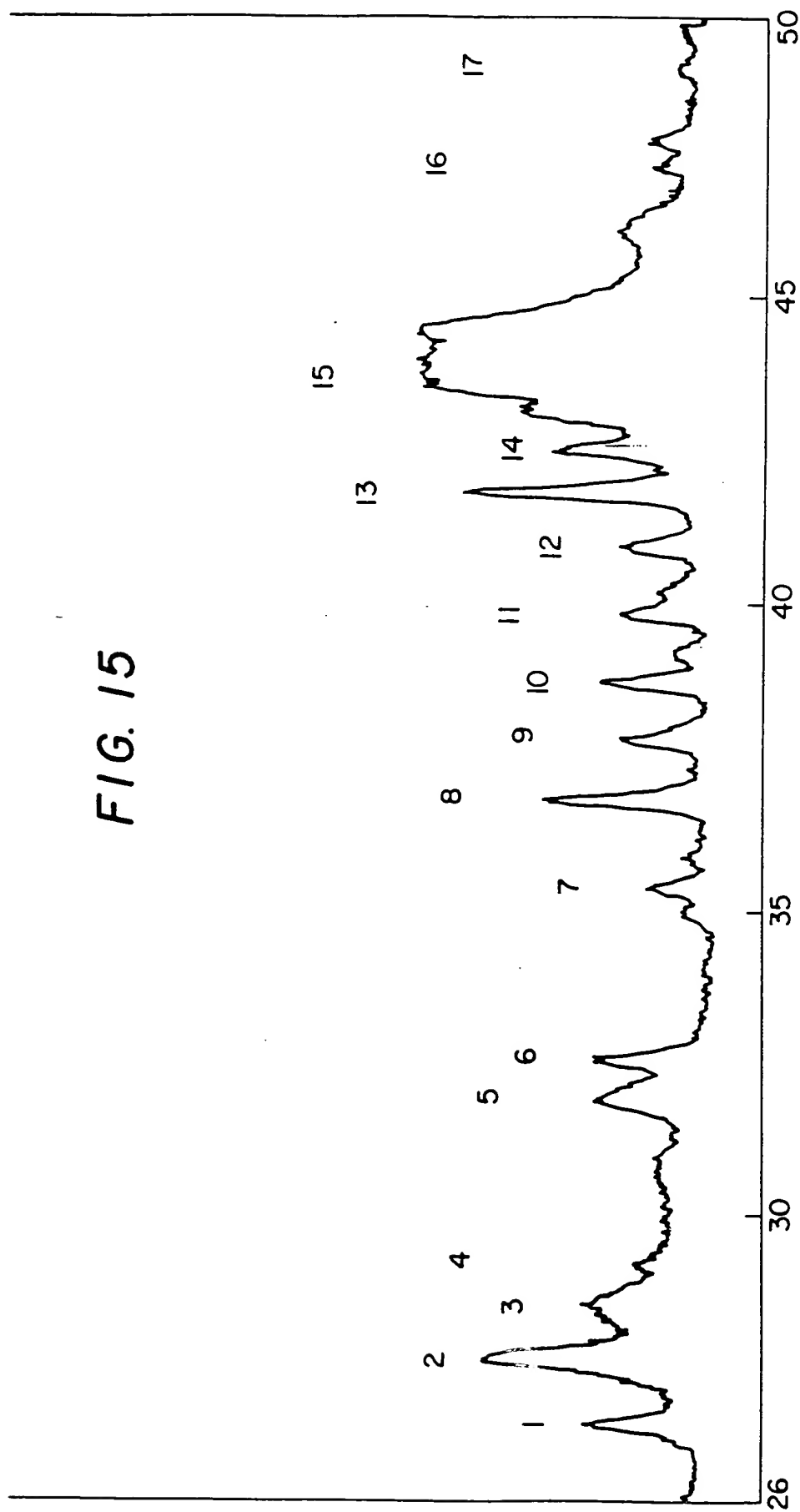
FIG. 13



FIG. 14

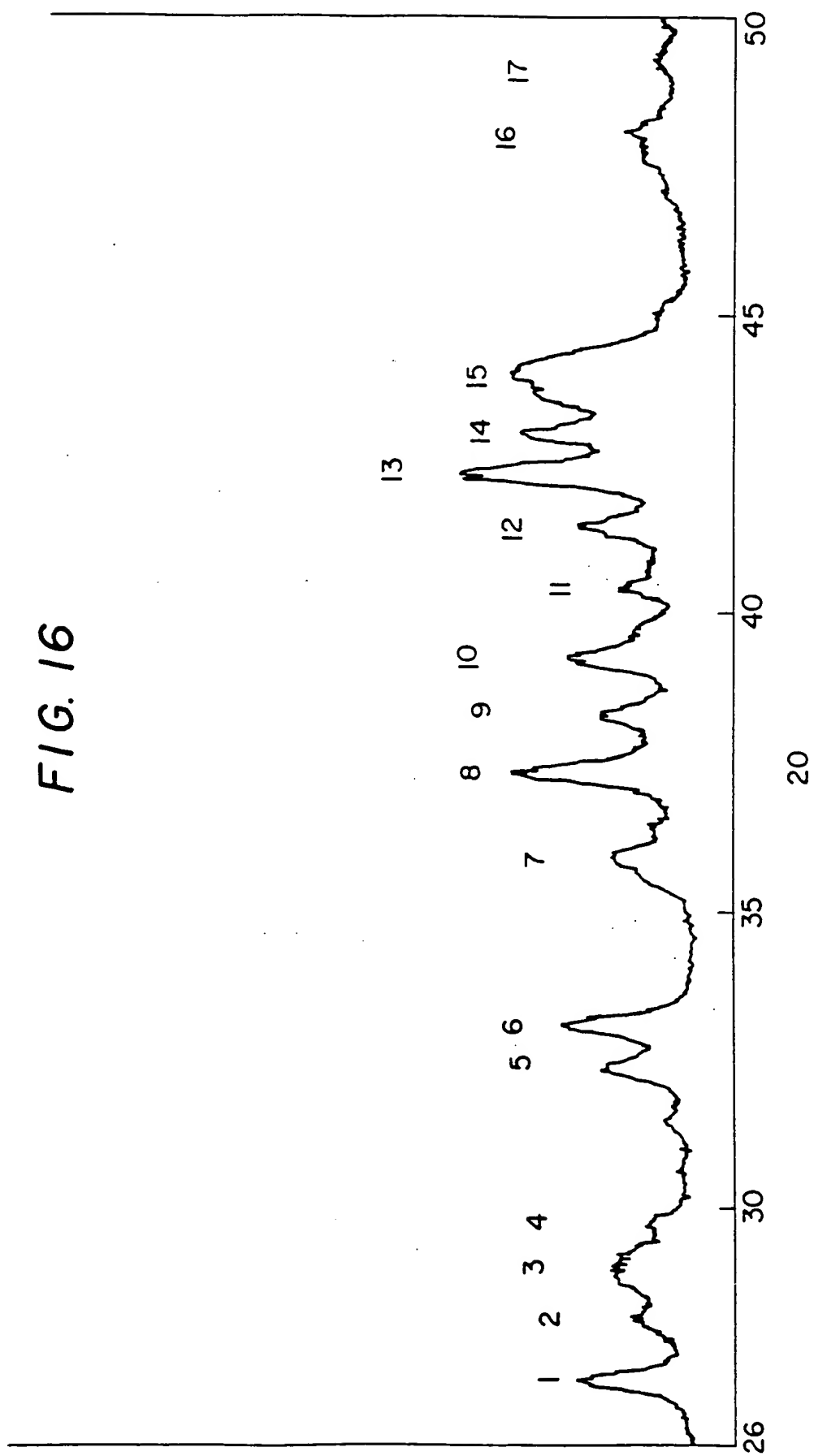
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FIG. 15



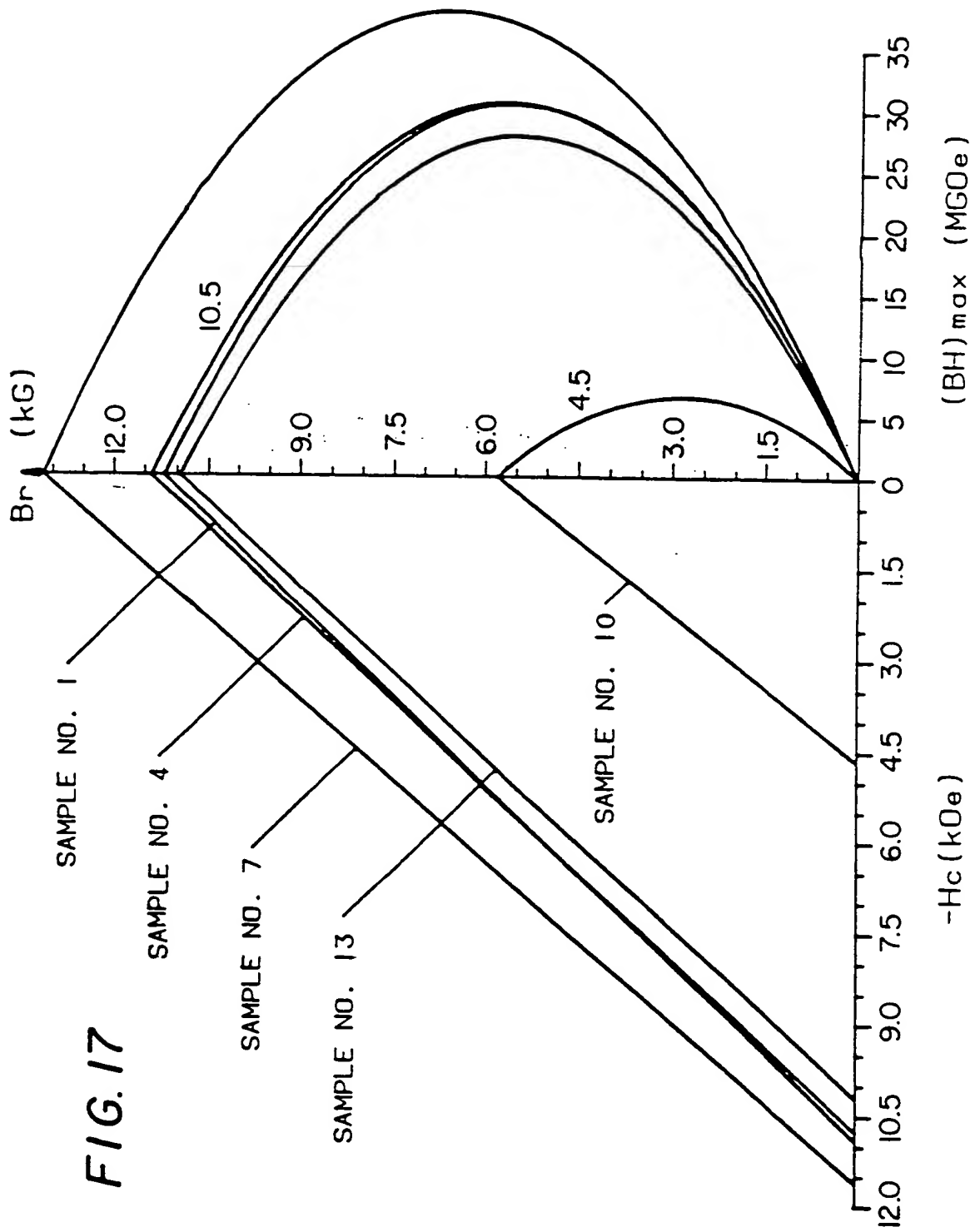
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FIG. 16



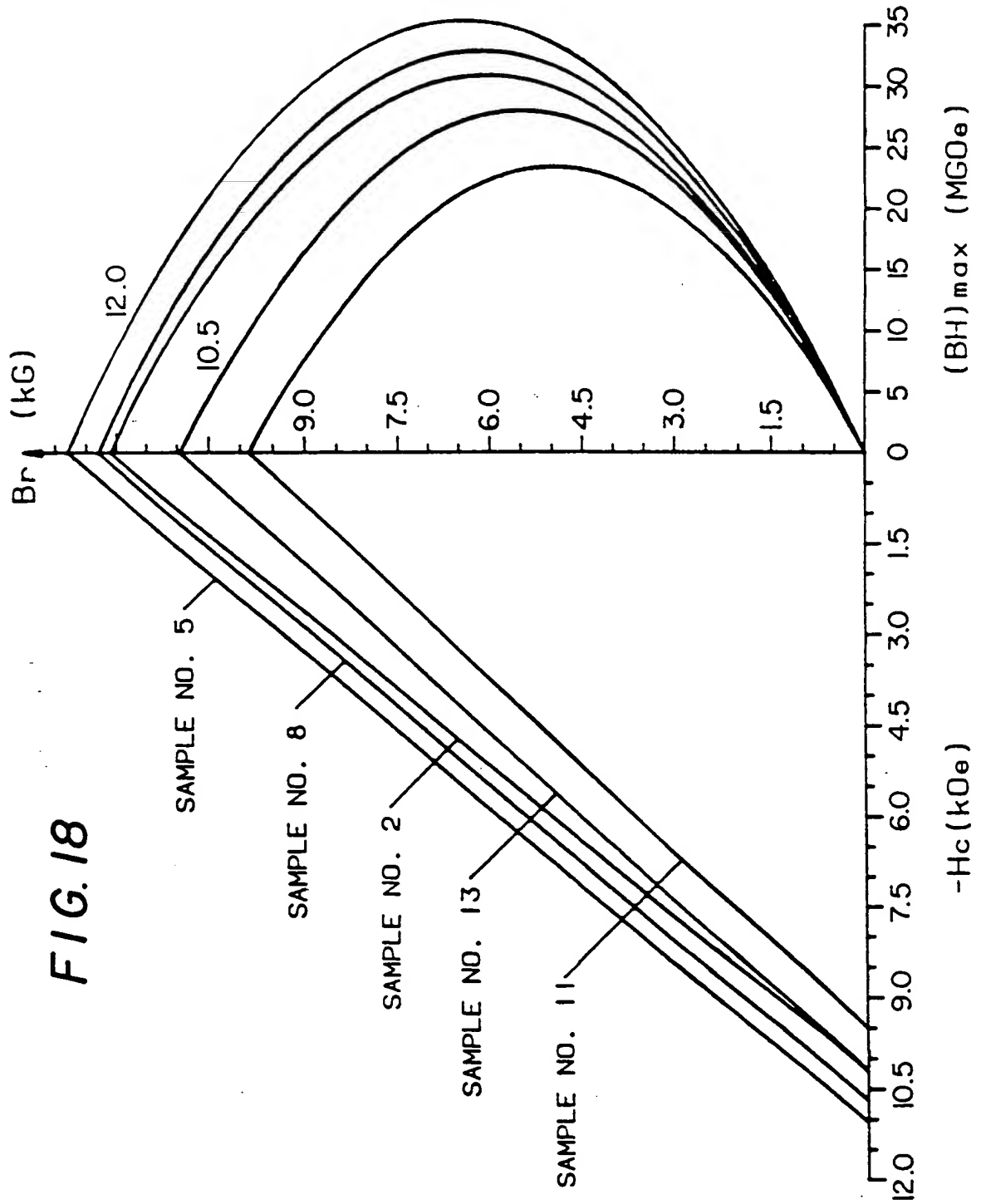
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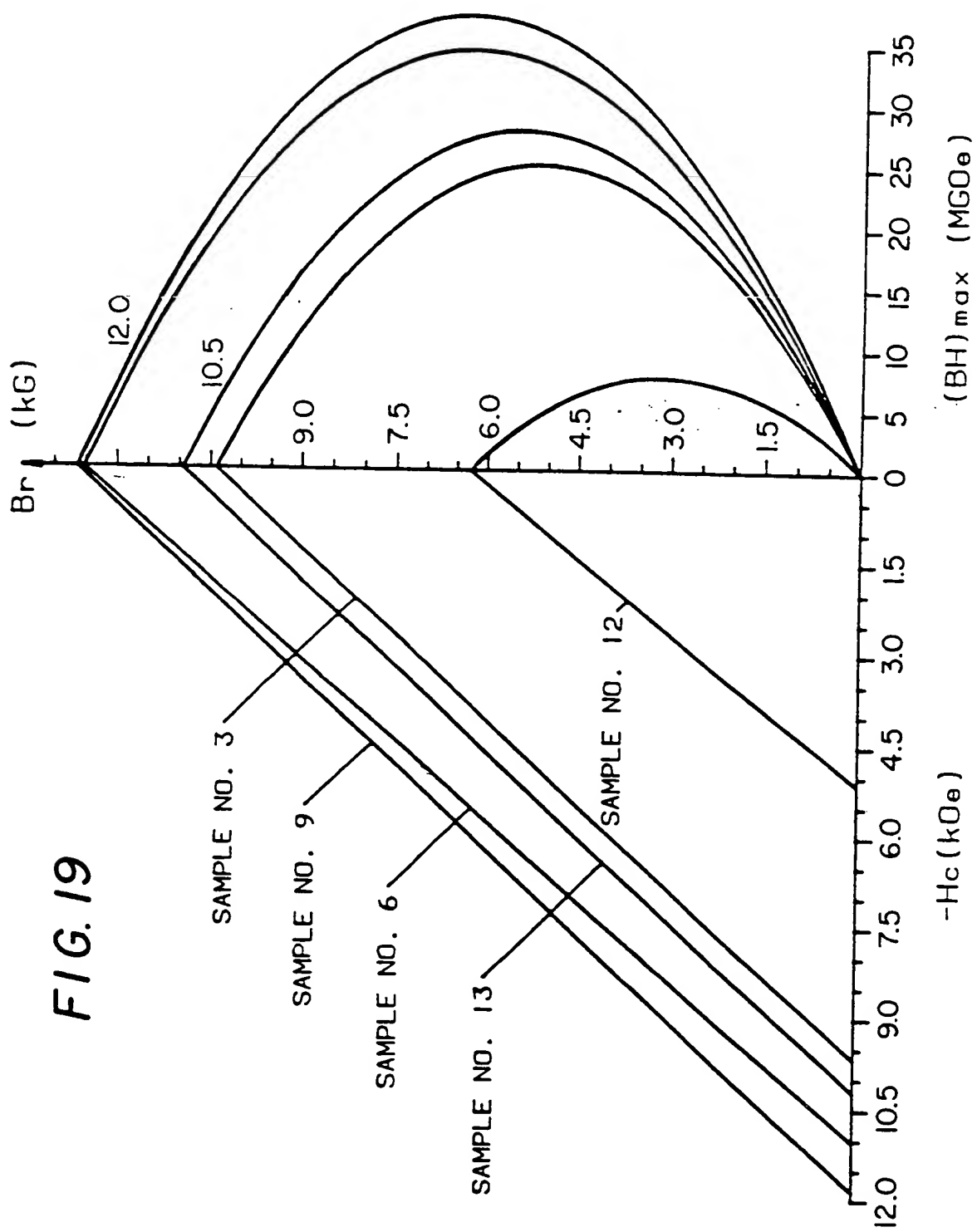
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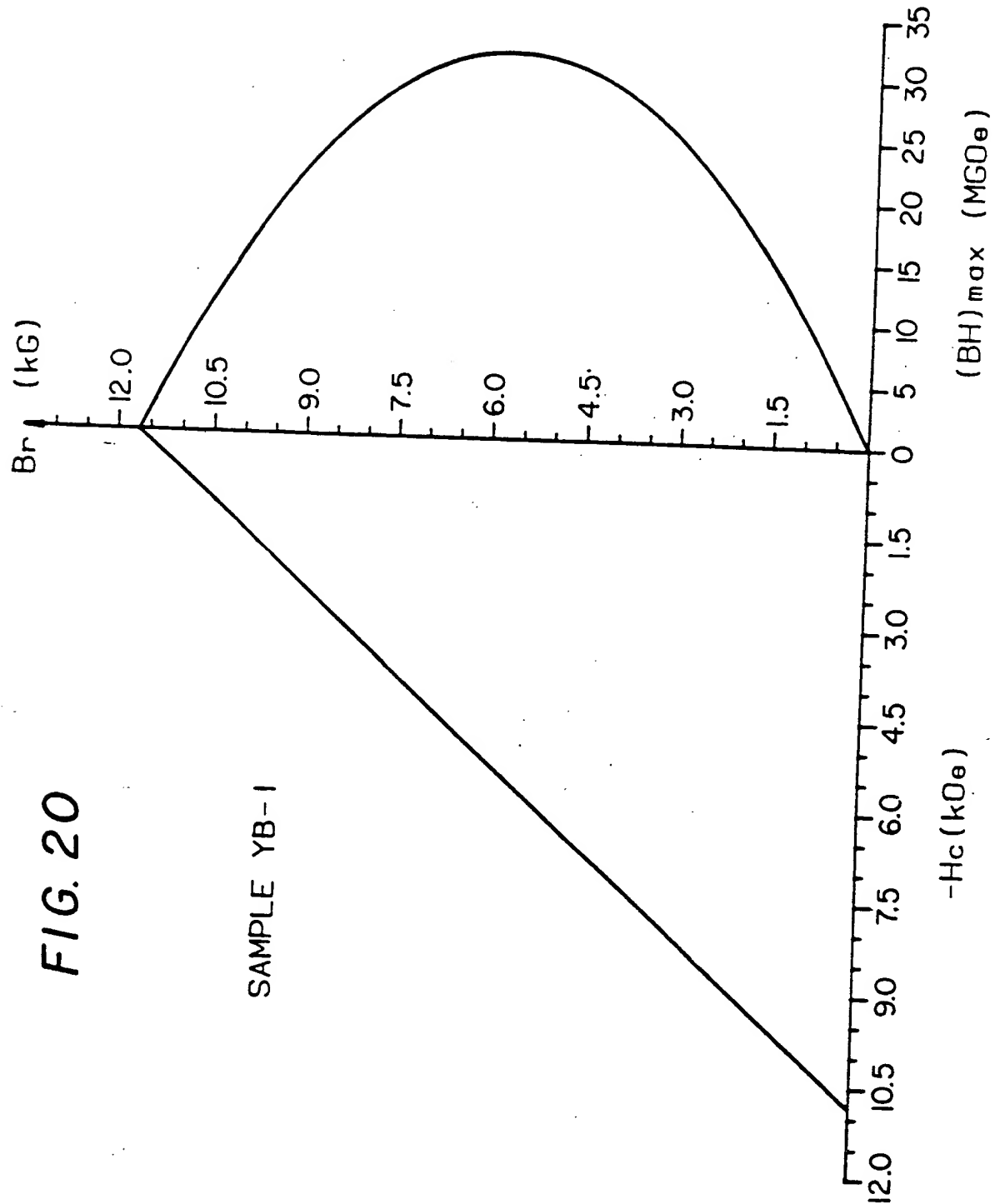
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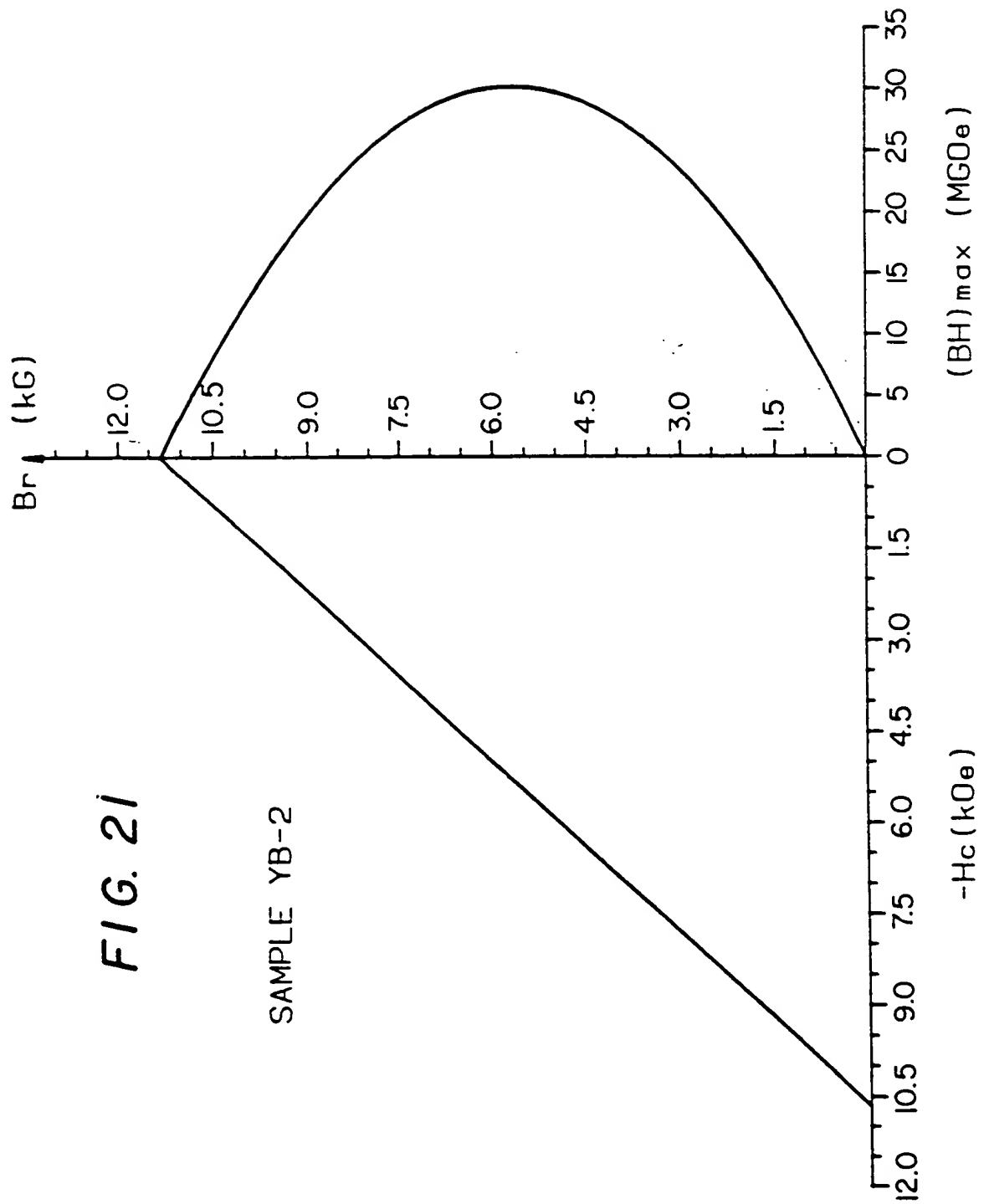


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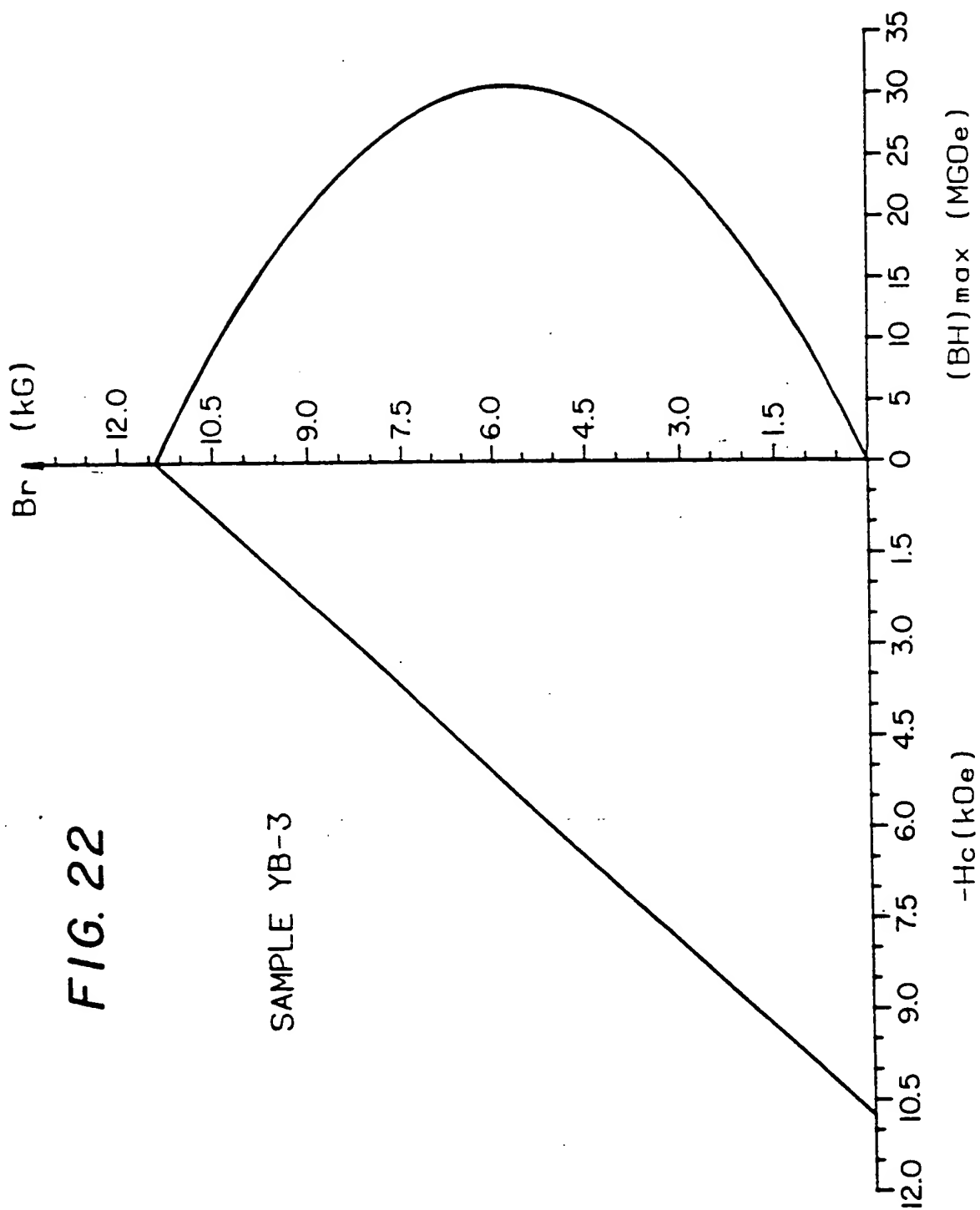
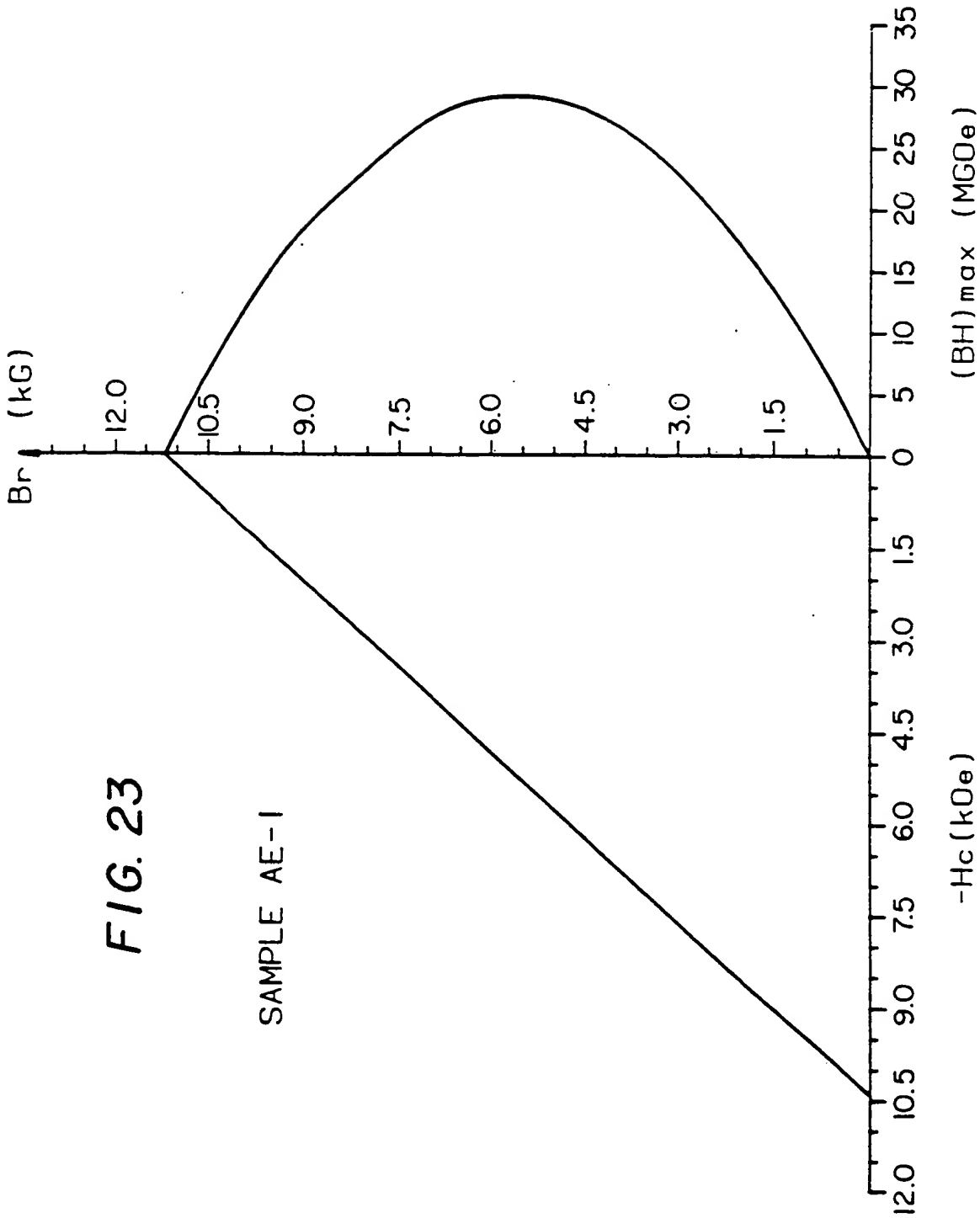


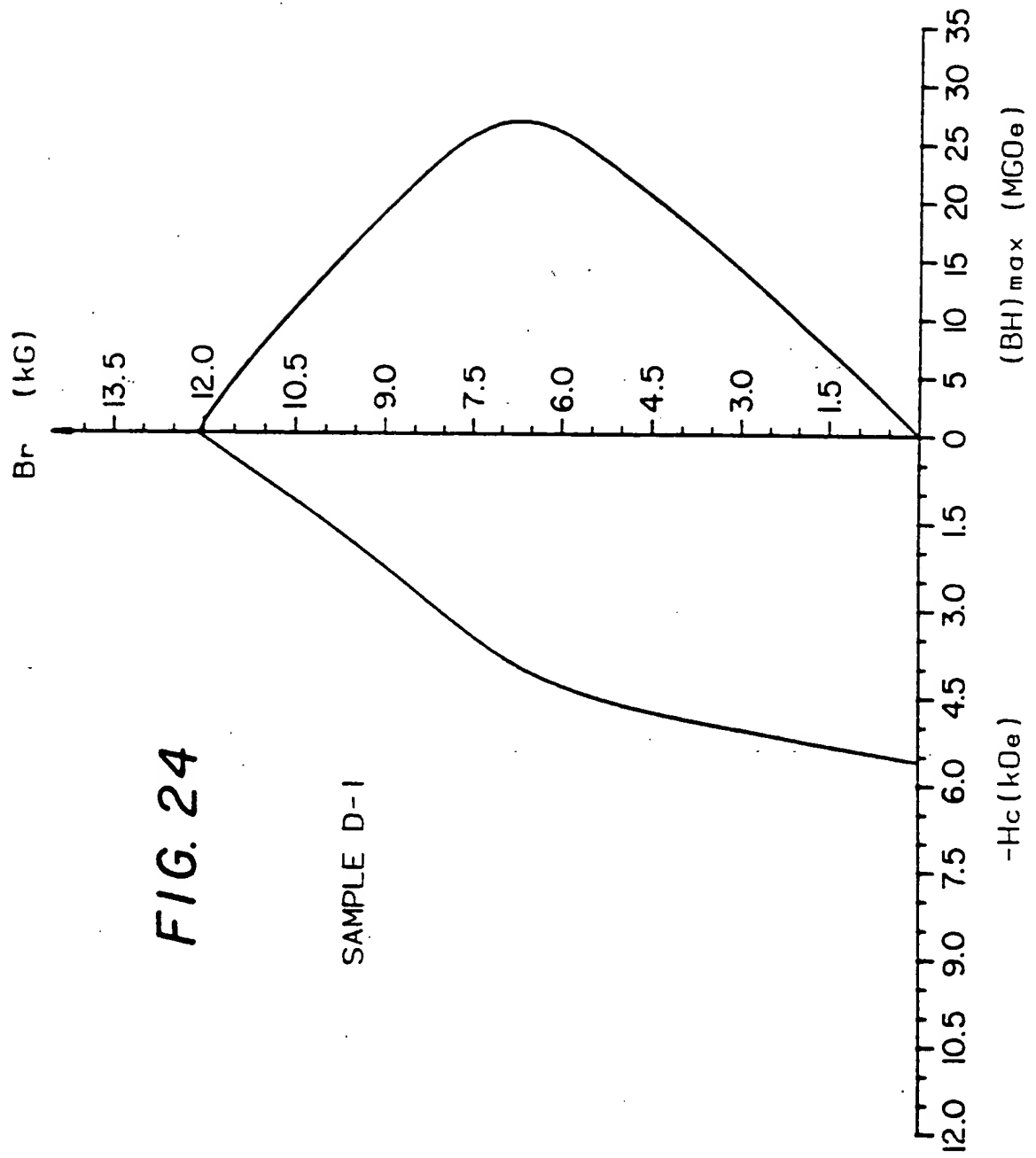
FIG. 22

SAMPLE YB-3

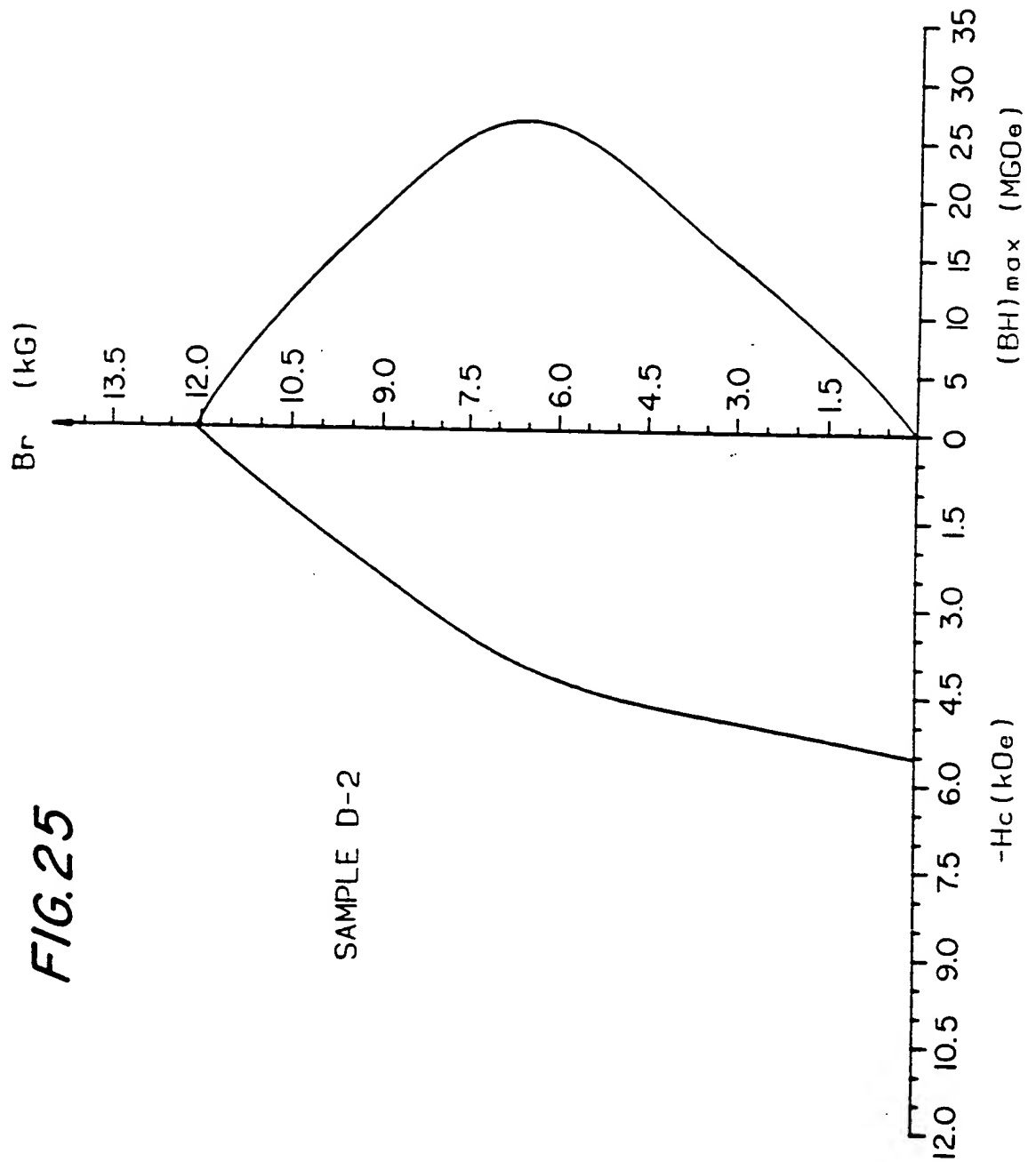
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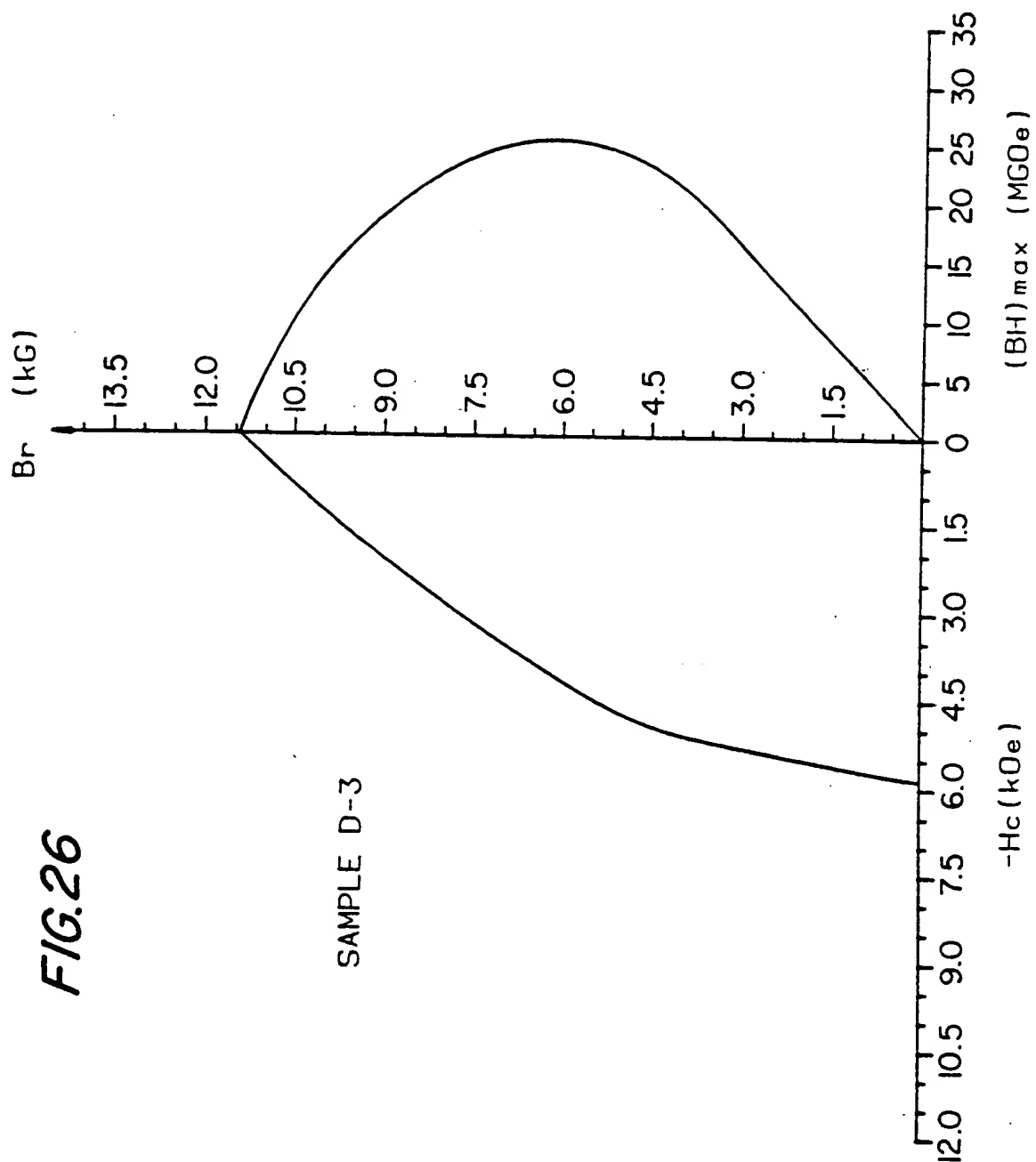
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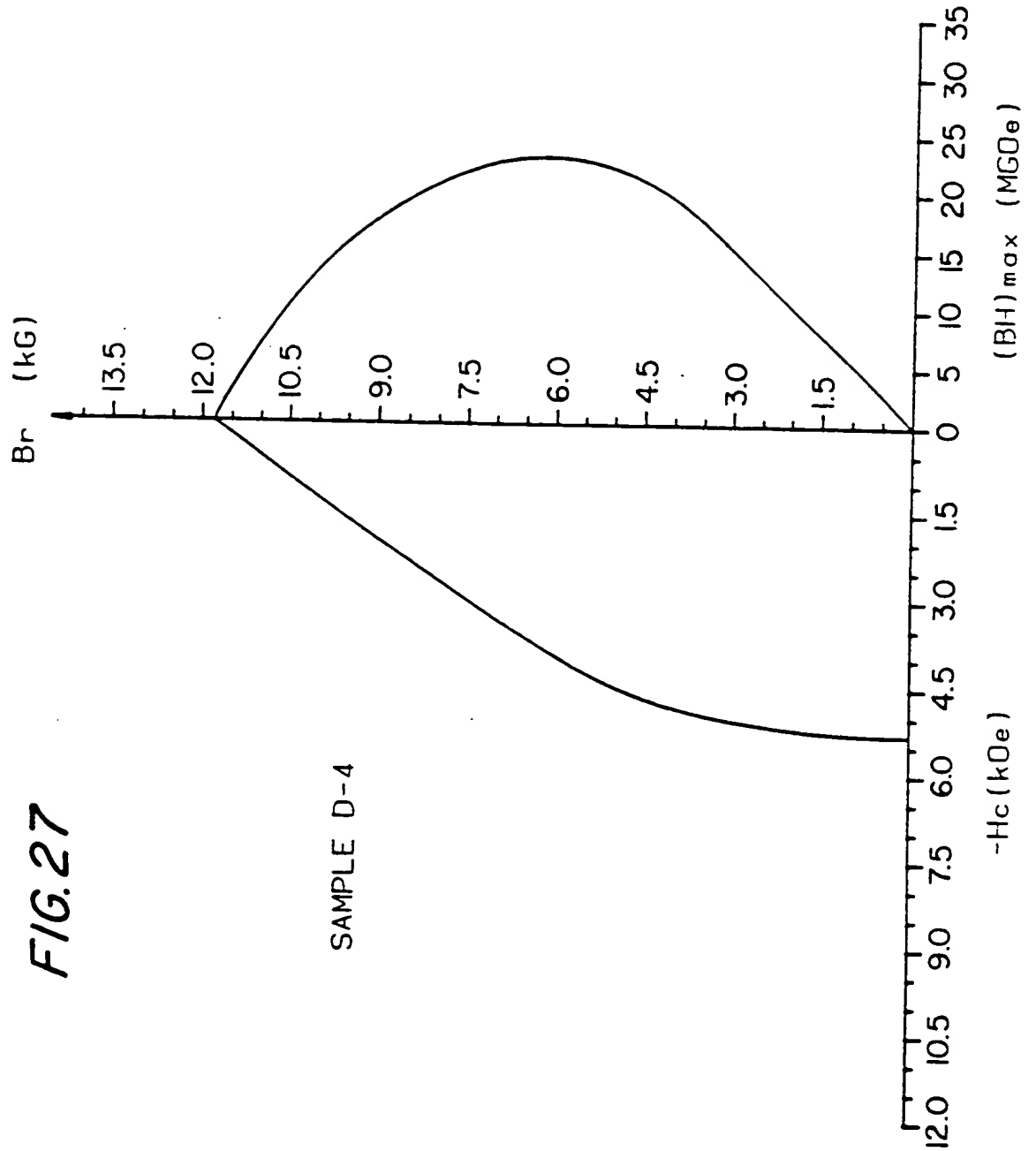


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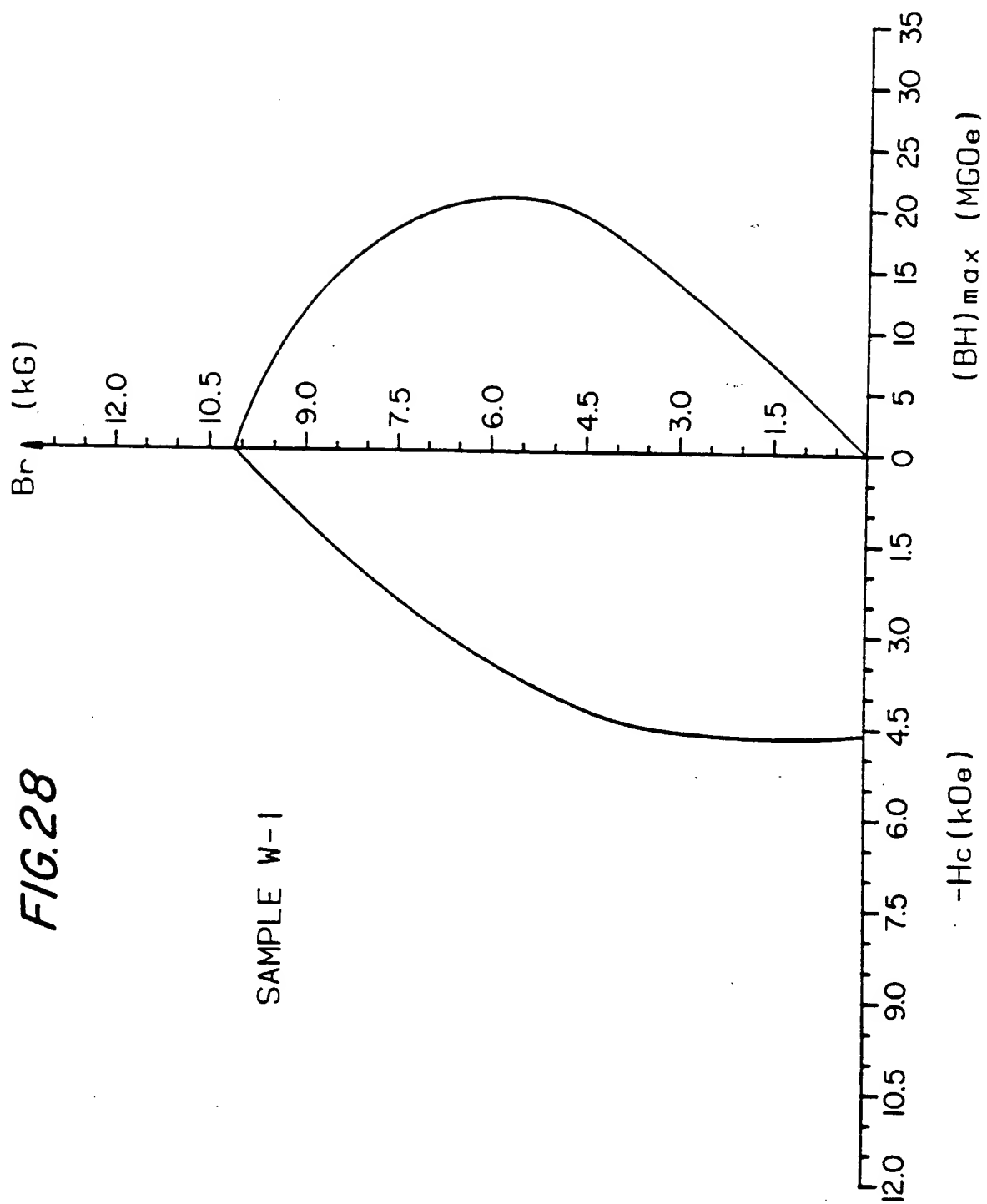
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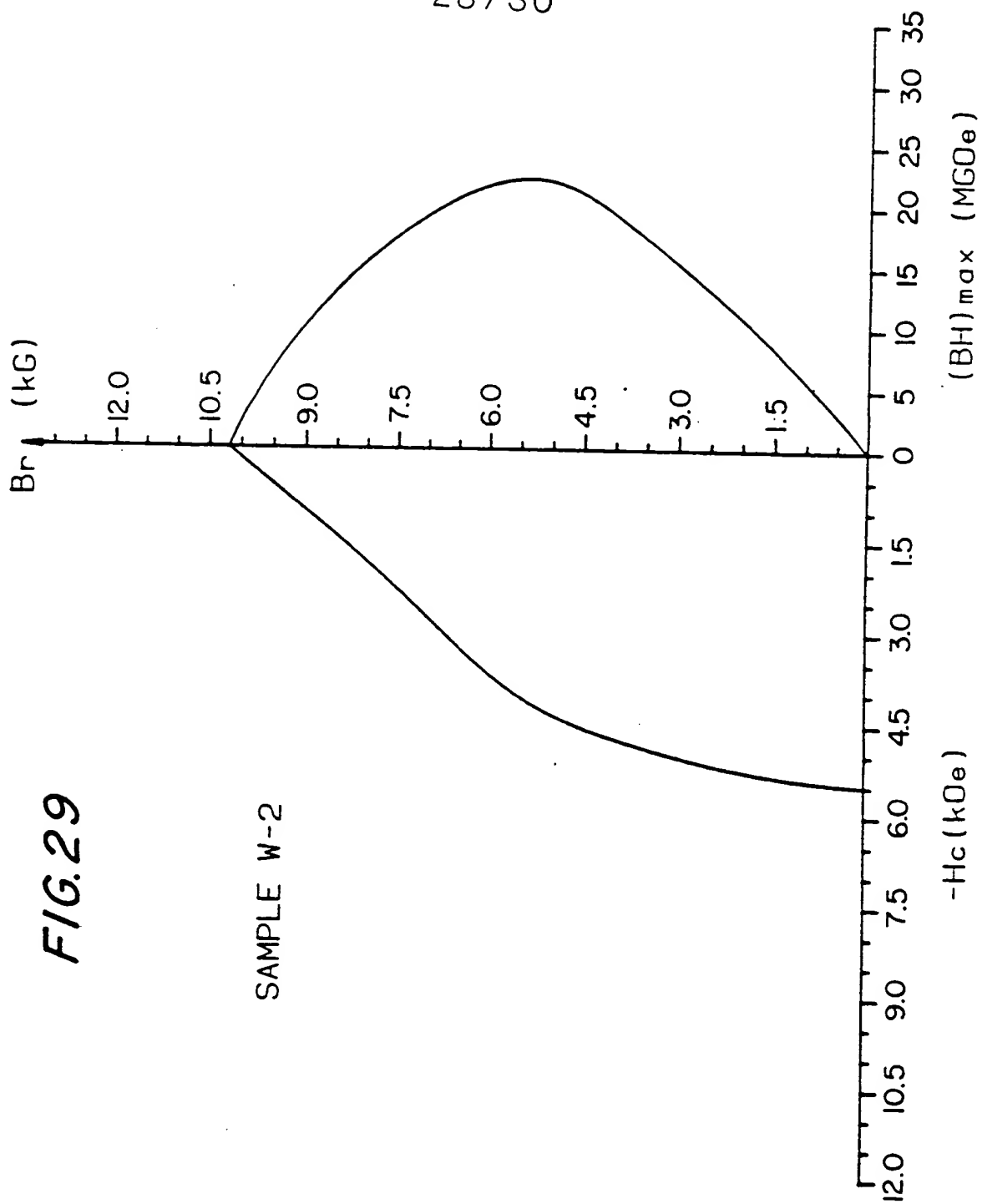


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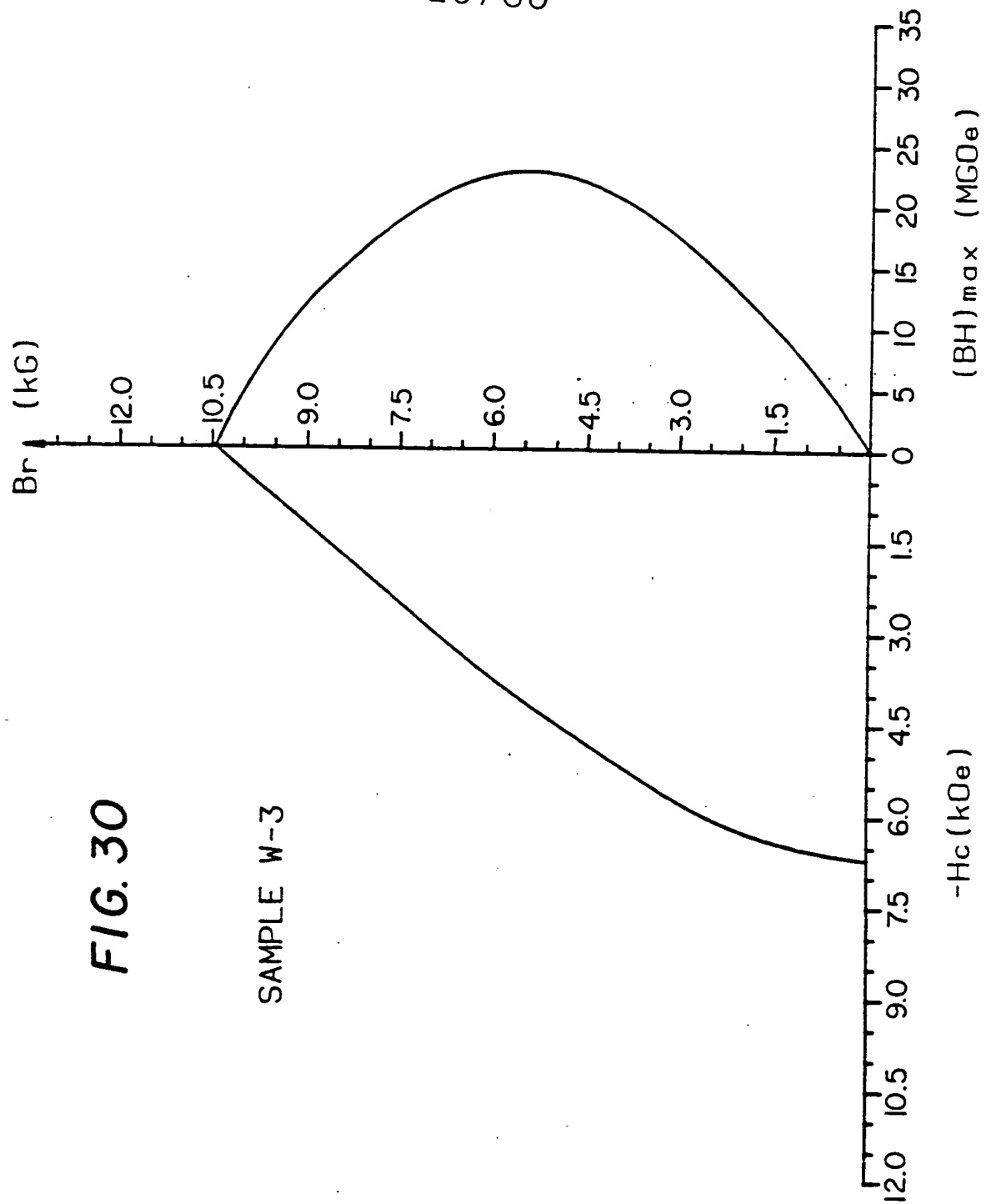
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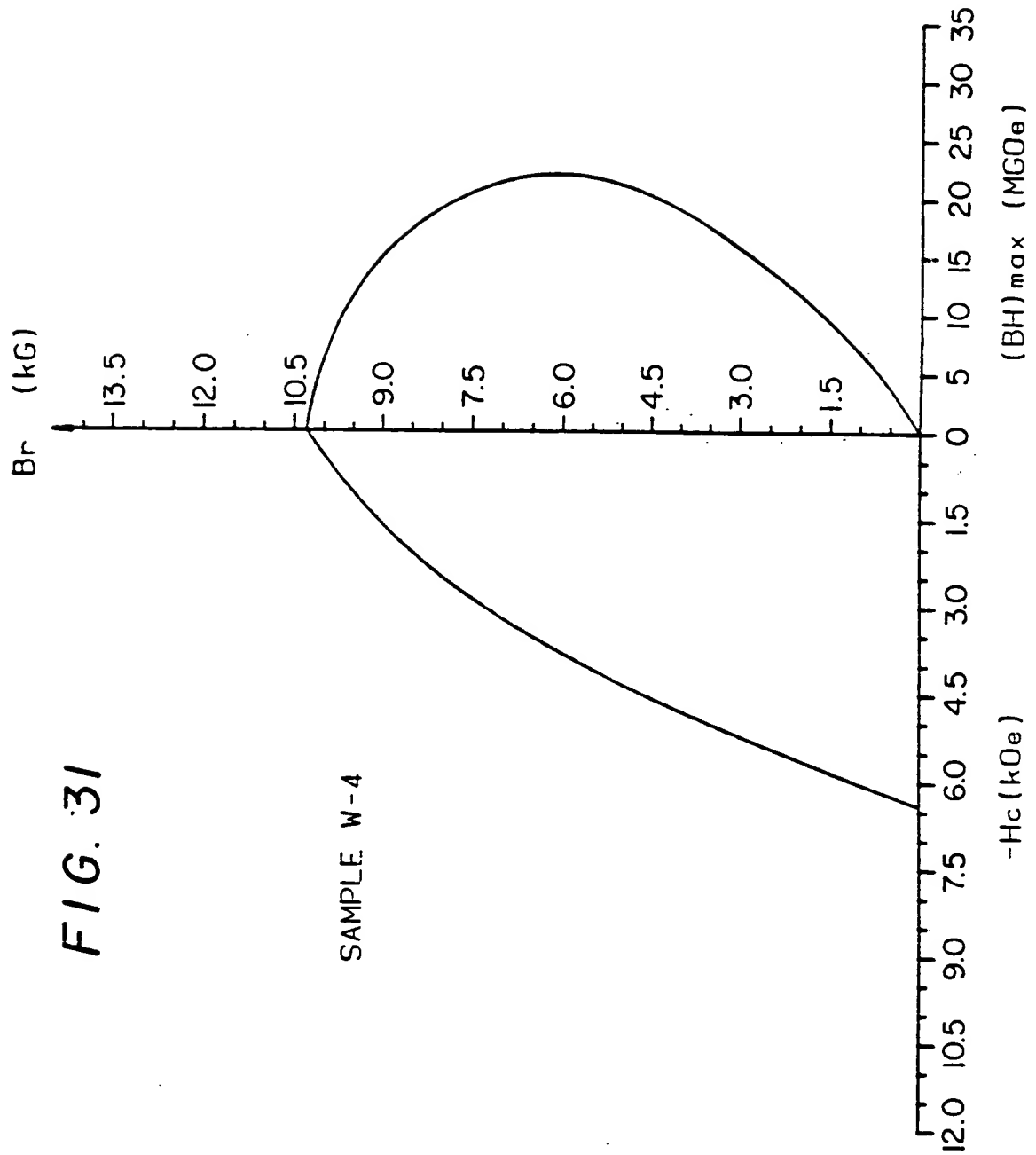
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FURTHER INFORMATION CONTINUED FROM THE SECOND SHEET

X	JP, A, 64-69001 (SUMITOMO METAL) 15 March 1989 see English language abstract	1-3, 6-11, 13-17, 49-51, 83-85, 97-99, 103
X	JP, A, 60-131949 (HITACHI) 13 July 1985 see English language abstract	1, 4, 16, 17 103
X	US, A, 4,322,257 (MENTH et al.) 30 March 1982 see column 5, lines 42-55	1-3, 5, 6, 8-12, 103

V. ☐ OBSERVATIONS WHERE CERTAIN CLAIMS WERE FOUND UNSEARCHABLE<sup>1</sup>

This international search report has not been established in respect of certain claims under Article 17(2) (a) for the following reasons:

1. ☐ Claim numbers \_\_\_\_\_, because they relate to subject matter not required to be searched by this Authority, namely:
  
2. ☐ Claim numbers \_\_\_\_\_, because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out<sup>2</sup>, specifically:
  
3. ☐ Claim numbers \_\_\_\_\_, because they are dependent claims not drafted in accordance with the second and third sentences of PCT Rule 6.4(a).

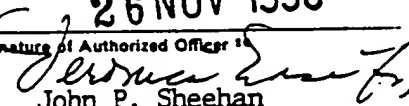
VI. ☐ OBSERVATIONS WHERE UNITY OF INVENTION IS LACKING<sup>3</sup>

This International Searching Authority found multiple inventions in this international application as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims of the international application.
  2. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims of the international application for which fees were paid, specifically claims:
  
  3. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claim numbers:
  
  4. ☐ As all searchable claims could be searched without effort justifying an additional fee, the International Searching Authority did not invite payment of any additional fee.
- Remark on Protest
- ☐ The additional search fees were accompanied by applicant's protest.
  - ☐ No protest accompanied the payment of additional search fees.

# INTERNATIONAL SEARCH REPORT

International Application No. **PCT/US90/03350**

<b>I. CLASSIFICATION OF SUBJECT MATTER</b> (if several classification symbols apply, indicate all) <sup>1</sup>		
According to International Patent Classification (IPC) or to both National Classification and IPC <b>IPC (5):</b> H01F 1/02 <b>U.S.Cl.:</b> 148/101		
<b>II. FIELDS SEARCHED</b>		
Minimum Documentation Searched <sup>4</sup>		
Classification System	Classification Symbols	
U.S.Cl.	148/101, 104, 105, 301, 302; 427/127, 215, 255.4, 399 428/403, 547; 241/18, 24; 419/12, 13, 14, 29, 30, 34, 35, 38 44, 55; 75/236, 238, 242, 243, 244	
Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched <sup>4</sup>		
<b>III. DOCUMENTS CONSIDERED TO BE RELEVANT</b> <sup>14</sup>		
Category <sup>6</sup>	Citation of Document, <sup>16</sup> with indication, where appropriate, of the relevant passages <sup>17</sup>	Relevant to Claim No. <sup>18</sup>
X	JP, A, 60-159152 (HITACHI), 20 August 1980	1-3, 5-11, 13-17, 20-24, 49-51, 83-85, 97-99, 103
P	US, A, 4,888,068 (TOKUNAGA et al.), 19 December 1989 See column 4 lines 46-59	1-3, 5-11, 13-17, 20-24, 49-51, 83-85, 97-99, 103
P	US, A, 4,902,357 (IMAIZUMI), 20 February 1990 See column 3 lines 53-62	1-4, 83-85 47-99
X	US, A, 4,043,845 (DIONNE), 23 August 1977 See entire document	3, 104
X	JP, A, 62-294159 (NAMIKI SEIMITSU HOS) 21 December 1987, see English language abstract	1-4, 52-54, 86-88, 100-102
X	JP, A, 55-11339 (SUWA SEIKOSHA KK) 26 January 1980 see English language abstract	1-4, 103
<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p><sup>15</sup> Special categories of cited documents:</p> <p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> </div> <div style="width: 45%;"> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.</p> <p>"&amp;" document member of the same patent family</p> </div> </div>		
<b>IV. CERTIFICATION</b>		
Date of the Actual Completion of the International Search <sup>1</sup>		Date of Mailing of this International Search Report <sup>1</sup>
06 September 1990		26 NOV 1990
International Searching Authority <sup>1</sup>		Signature of Authorized Officer <sup>18</sup>
ISA/US		 John P. Sheehan

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